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Contract

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This document contains detailed information about layouts equipment and processes  
for this RCC (Resource Control Center). *+*14. SUBJECT TERMS MAINTENANCE, DATABASE, EQUIPMENT,  
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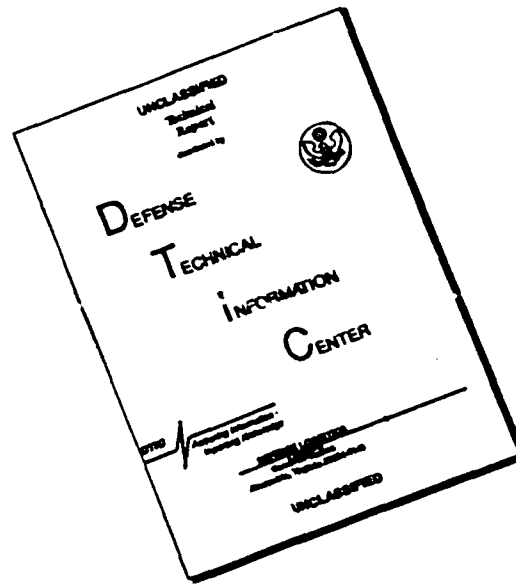
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**TECHNOLOGY INSERTION-ENGINEERING SERVICES  
PROCESS CHARACTERIZATION  
TASK ORDER NO. 1**

**BOOK 2 OF 3**

**DATABASE DOCUMENTATION BOOK**

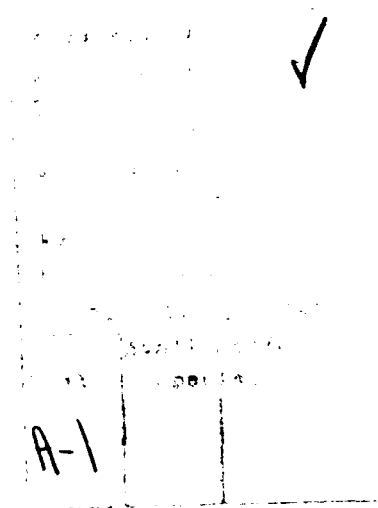
**OO-ALC**

**MANPGP**

**(WHEELS - WCD'S)**

**CONTRACT SUMMARY REPORT  
15 DECEMBER 1989**

**CONTRACT NO. F33600-88-D-0567  
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**MCDONNELL DOUGLAS**  
*McDonnell Douglas Missile Systems Company*  
*St. Louis, Missouri 63166-0516 (314) 232-0232*

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9













WHEEL / BRAKE  
A-7

- 1- 13101N ~~DELETED~~
- 2- 13102N ~~DELETED~~
- 3- 13103N ~~DELETED~~
- 4- 13104N ~~DELETED~~
- 5- 13105N ~~DELETED~~
- 6- 13106N ~~DELETED~~
- 7- 13150N NOSE ASSY 2P
- 8- 13151N NOSE OUTBOARD 2P
- 9- 13152N NOSE INBOARD 2P

BRAKE

- 1- 13201N BRAKE ASSY 2RP
- 2- 13202N TORQUE <sup>PLATE</sup> ~~FORCE~~ 2RP
- 3- 13203N CARRIER & LINING 2RP
- 4- 13204N PRESSURE PLATE 2RP
- 5- 13205N Brake Assy 2RP
- 6- 13206N Torque Plate Assy 2RP
- 7 13207N Disk and Linings Assy

WHEELS/BRAKES  
A-10

- 1-38101N MLC INBOARD ZRP
- 2-38102N MLC ASSY ZRP
- 3-38107N MLC OUTBOARD ZRP
- 4-38150N NLG INBOARD ZRP
- 5-38151N NLG OUTBOARD ZRP
- 6-38152N NLG ASSY ZRP

BRAKES

- 1-38201N BRAKE ZRP
- 2-38202N TORQUE TUBE ZRP
- 3-38203N ROTATING DISK ZRP
- 4-38204N STATIONARY DISK ZRP
- 5-38205N BACKING PLATE ZRP
- 6-38207N PRESSURE PLATE ZRP
- 7-38206N BRAKE ASSY ZRP

A-37

~~BRAKE~~

- 1-12201N BRAKE HOUSING ZRP
- 2-12202N NOT FOUND. DELETED
- 3-12203N TORQUE TUBE ZRP
- 4-12204N BACKING PLATE ZRP
- 5-12205N PRESSURE PLATE ZRP
- 6-12206N STATOR ZRP
- 7 12207N Brake ASSY

# B-52 WHEELS

Pull

- 1 16101N MLC INBOARD ZRP
- 2 16102N MLC OUTBOARD ZRP
- 3 16103N WHEEL IS CONDEMNED IN DISASSY ZRP
- 4 16104N MLC OUTBOARD ZRP
- 5 16105N MLC INBOARD ZRP
- 6 16106N MLC WHEEL ASSY ZRP
- 7 16107N W/H IS CONDEMNED IN DISASSY ZRP NO 958
- 8 16108N W/H IS CONDEMNED IN DISASSY ZRP NO 958
- 9 16109N MLC WHEEL ASSY ZRP

# BRAKES

Pull

- 1-16201N CARRIER ASSY ZRP 17-16206N ~~Compressor~~
- 2-16202N PRESSURE PLATE ZRP 18-16209N ~~Link Assn~~ ZRP
- 3-16203N STATOR PLATE ZRP
- 4-16205N ROTOR SEGMENT ASSY ZRP
- 5-16206N HYDRAULICS
- 6-16207N
- 7-16208N
- 8-16209N
- 9-16210N
- 10-16211N
- 11-16212N
- 12-16213N
- 13-16214N
- 14-16215N
- 15-16217N
- 16-16204N Backing Plate B-52 ZRP

# C-5A & B WHEELS

Pull

- 1- 21101N NLG WHEEL ASSY ZRP 2113- 21159N N Wheel misc S
- 2- 21103N NLG INBOARD ZRP 2114- 21160N M Wheel misc S
- 3- 21104N NLG OUTBOARD ZRP 2115- 21161N M Wheel misc S
- 4- 21150N NLG OUTBOARD ZRP 2116- 21162N M Wheel misc S
- 5- 21151N NLG INBOARD ZRP
- 6- 21152N NLG ASSY ZRP
- 7- 21153N NLG Insert Cap ZRP
- 8- 21154N M Wheel Cup ZRP
- 9- 21155N M Wheel Cup ZRP
- 10- 21156N N Wheel Cup ZRP
- 11- 21157N N Wheel <sup>MISC</sup> S-2 ZRP
- 12- 21158N N Wheel <sup>MISC</sup> S-11 ZRP

## C-5A & B BRAKES

- 21201N Backing Plate ZRP
- 1- 21202N STATOR/CARRIER CS ZRP
- 2- 21203N ROTOR/CARRIER CS ZRP
- 3- 21204N END PLATE/CARRIER CS ZRP
- 4- 21205N DELETE
- 5- 21206N HOUSING PISTON ASSY ZRP
- 6- 21207N TORQUE TUBE ZRP
- 7- 21208N Brake Assy ~~DELETE~~ ZRP
- 8- 21209N Pressure Plate Assy ZRP
- 9- 21210N Brake Torque Tube Assy ZRP
- 10- 21211N Tube Torque ZRP
- 11- 21212N Torque Tube Assy ZRP
- 12- 21213N Disk Rotor Assy ZRP
- 13- 21214N Disk - STATOR ZRP
- 14- 21215N Spacer Plate ZRP
- 15- 21216N BRAKE ASSY ZRP

## C-7A WHEELS

- 1- 20102N WHEEL INBOARD ZDP
- 2- 20103N WHEEL OUTBOARD ZDP
- 3- 20104N WHEEL ASSY ZDP

## BRAKES

- 1- 20201N DELETED/NO Q/N

## C-130 WHEELS

- 1-18104N MLC WHEEL ASSY (DELETED)
- 18106N MLC WHEEL INBOARD ZRP
- 18108N MLC WHEEL ASSY ZRP
- 1-18108N MLC WHEEL OUTBOARD ZRP
- 18111N MLC WHEEL ASSY ZRP
- 18112N MLC WHEEL INBOARD ZRP
- 18113N MLC WHEEL OUTBOARD ZRP
- 3-18150N NLG WHEEL ASSY ZRP
- 1-18151N NLG WHEEL ASSY (NAVY TO. REQUESTED DELETED)
- 1-18152N NLG WHEEL OUTBOARD ZRP
- 2-18153N NLG WHEEL INBOARD ZRP
- 3-18154N NLG WHEEL INBOARD (NAVY) ZRP
- 1-18155N NLG WHEEL OUTBOARD (NAVY) ZRP
- 5-18156N NLG WHEEL ASSY (NAVY) ZRP



## VC-130 BRAKES

- 1-18201N TORQUE TUBE ZRP
- 2-18202N PRESSURE PLATE ZRP
- 3-18203N BRAKE 130 ZRP
- 4-18204N BRAKE ASSY ZRP
- 5-18205N
- 6-18206N BRAKE DELETED
- 7-18207N BRAKE ASSY DELETED
- 8-18208N HOUSING DELETED
- 9-18209N ROTATING DISK ZRP
- 10-18210N ROTOR ZRP
- 11-18211N BACKING PLATE ZRP
- 12-18212N STATOR ZRP
- 13-18213N PLATE Subassembly ZRP
- 14-18214N Brake ASSY ZRP
- 15-18215N Brake Assy ZRP
- 16-18216N Housing Assy ZRP

## WHEELS/ BRAKES

C-141

- 1-19102N M/W OUTBOARD ZRP
- 2-19103N M/W OUTBOARD ZRP
- 3-19104N M/W INBOARD ZRP
- 4-19105N M/W ASSY
- 5-19106N M/W ZRP
- 6-19107N M/W ASSY ZRP
- 7-19108N M/W OUTBOARD ASSY ZRP

- 1-19201N PLATE BACKING W
- 2-19202N BRAKE ASSY W
- 3-19203N TORQUE TUBE W
- 4-19204N ROTATING DISK W
- 5-19205N PRESSURE PLATE W

## WHEELS/BRAKES

E-3A

- 1- 39101N WHEEL ASSY 2PP
- 2- 39102N W/H INBOARD 2PP
- 3- 39103N W/H OUTBOARD 2PP
- 4- 39150N NOSE W/H ASSY 2PP
- 5- 39151N NOSE W/H INBOARD 2PP
- 6- 39152N NOSE W/H OUTBOARD 2PP

## BRAKES

- 1- 39201N BRAKE ASSY W
- 2- 39202N ROTATING DISK W
- 3- 39203N PRESSURE PLATE W
- 4- 39204N STATIONARY DISK W
- 5- 39205N BACKING PLATE W
- 6- 39206N Torque Tube
- 7- 39207N Deleted.
- 8- 39208N BRAKE ASSY W

## WHEELS/BRAKES

F-4

- 1- 01101N W/H DEMOUNTABLE, M ZRP
- 2- 01102N W/H FLANGE, M ZRP
- 3- 01103N WHEEL, M
- 4- 01104N WHEEL FLANGE, M
- 5- 01105N SLEEVE BUSHING, M ZRP
- 6- 01106N RING EXCITER, M ZRP
- 7- 01107N W/H ASSY, M ZRP
- 8- 01108N NOSE WHEEL, M
- 9- 01150N W/H OUTBOARD, N ZRP
- 10- 01151N W/H OUTBOARD, N ZRP
- 11- 01152N RING, BEARING ADJ., M ZRP
- 12- 01153N W/H INBOARD, N ZRP
- 13- 01154N WHEEL ASSY, N ZRP
- 14- 01155N W/H INBOARD, N ZRP
- 15- 01156N WHEEL ASSY, N ZRP

## BRAKES

- 1- 01202N BRAKE HOUSING F4C ZRP
- 2- 01207N HOUSING ASSEMBLY ZRP

# WHEELS / BRAKES

F-5

Paul  
Wheels  
only

- 1-34101N FLANGE, M/W ERP
- 2-34102N WHEEL ASSY, M ERP
- 3-34103N WHEEL ASSY, M ERP
- 4-34104N WHEEL DEMOUNTABLE, M ERP
- 5-34105N WHEEL ASSY, M ERP
- 6-34106N WHEEL ~~WHEEL~~ HUB ERP
- 7-34107N FLANGE, M ERP
- 8-34108N WHEEL OUT BOARD ERP
- 9-34109N WHEEL IN BOARD ERP

## BRAKES

- |   |                                   |
|---|-----------------------------------|
| 1-34201N Plate Sub. ASSY PWR ERP                | 14-34214N - Brake AS <sup>2</sup> |
| 2-34202N ROTATING DISK ERP                      |                                   |
| 3-34203N STATIONARY DISK ERP                    |                                   |
| 4-34204N <del>BRAKE ASSY</del> HOUSING ASSY ERP |                                   |
| 5-34205N DISK SECONDARY ERP                     |                                   |
| 6-34206N TORQUE TUBE ERP                        |                                   |
| 7-34207N TORQUE TUBE ERP                        |                                   |
| 8-34209N PRESSURE PLATE ERP                     |                                   |
| 9-34210N BACKING PLATE ERP                      |                                   |
| 10-34208N ROTATING DISK ERP                     |                                   |
| 11-34211N STATOR ERP                            |                                   |
| 12-34212N Brake ASSY ERP                        |                                   |
| 13-34213N DISK ASSY ERP                         |                                   |

WHEELS/ BRAKES  
F-15

- 1-36101N WHEEL INBOARD, M-
- 2-36103N WHEEL INBOARD C/D 2DP
- 3-36104N WHEEL ASSY C/D 2DP
- 4-36105N WHEEL OUTBOARD, M 2DP
- 5-36106N WHEEL FLANGE-
- 6-36107N ROTOR DRIVE KEYS 2DP
- 7-36108N WHEEL ASSY, M-
- 8-36150N WHEEL HALF OUTBOARD 2DP
- 9-36152N WHEEL HALF INBOARD 2DP
- 10-36153N WHEEL ASSY 2DP
- 36154N DRIVE KEY DRIVE-

BRAKES

- 1-36203N BRAKE ASSY AB 2DP
- 2-36204N HOUSING A/B 2DP
- 3-36205N BACKING PLATE
- 4-36206N BRAKE HOUSING C/D
- 5-36207N TUBE, TORQUE C/D
- 6-36208N BOLTS 2DP
- 36209N TORQUE TUBE A/B 1DP
- 8-36210N DELETED
- 9-36212N BOLT

- 36213N ROTATING DISK A/B
- 11- 36214N STATIONARY DISK A/B
- 12- 36215N ROTATING DISK A/B ZRP
- 13- 36216N END PLATE A/B ZRP
- 14- 36217N PRESSURE PLATE A/B ZRP
- 15- 36218N STATIONARY DISK A/B ZRP
- 16- 36219N BACKING PLATE C/D
- 17- 36220N STATIONARY DISK C/D
- 18- 36221N ROTATING DISK C/D
- 19- 36222N PRESSURE PLATE C/D
- 20- 36223N BRAKE HEAT STACK C/D
- 21 36224N HEAT SHIELD, HOUSING ZRP
- 36225N END PLATE
- 23 36226N PRESSURE PLATE
- 24 36227N DISK SUBASSY, STATOR
- 25 36228N HEAT STACK ASSY
- 26 36229N BRAKE ASSY
- 27 36230N END ~~PLATE~~ PLATE
- 28 36231N PRESSURE PLATE ASSY
- 29 36232N DISK SUBASSY, STATOR
- 30 36233N ROTOR SUB ASSY
- ~~31- 36234N~~ ~~HEAT STACK ASSY~~ BRAKE ASSY
- ~~32- 36235N~~ ~~HEAT STACK ASSY~~
- 33 36236N HEAT STACK ASSY ZRP

F15  
Brake

WHEELS / BRAKES  
F-16

- 1-37101N WHEEL INBOARD, M 1AP
- 2-37102N WHEEL FLANGE, M 1AP
- 3-37103N WHEEL ASSY, M 1AP

✓ F-16 BRAKES

- 1-37201N ~~BRAKE ASSY~~ HOUSING 2AP
- 2-37202N TORQUE TUBE 2AP
- 3-37203N BACKING PLATE 2AP
- 4-37204N ROTATING DISK 2AP
- 5-37205N PRESSURE PLATE 2AP
- 6-37206N STATIONARY DISK 2AP
- 7-37207N END PLATE 2AP
- 8-37208N Heat Stack ASSY 2AP
- 9-37209N Brake ASSY 2AP
- 10-37210N Brake ASSY 2AP
- 11-37211N End Plate 2AP



## F-16 Brakes

- 12- 37212N STATIONARY DISK ZRP
- 13- 37213N Pressure PLATE ZRP
- 14- 37214N ROTATING DISK. ZRP
- 15- 37215N Heat Stack ASSY ZRP

WHEELS/BRAKES  
F-100

- 1- 02100N INBOARD W/H HALF DRP
- 2- 02101N OUTBOARD W/H HALF DRP
- 3- 02103N INBOARD W/H DRP
- 4- 02104N M/W ASSEMBLY DRP
- 5- 02105N M/W ASSEMBLY DRP
- 6- 02102N M/W OUT BOARD DRP
- 7 04104N M/W F-100/F-106 ASSY DRP
- 8 04103N I.B. F-100/F-106 DRP
- 9 04101N O.B F-100/F-106 DRP

✓ BRAKES

- 1- 02201N Brake Assy
- 2- 02202N Hub Assy
- 3- 02203N Ring
- 4 02204N Rotating Disk

✓F-104

**BRAKE**

- 1-07201N w Plate STATOR
- 2-07202N w Pressure PLATE
- 1-07203N w Brake ASSY
- 1-07204N w Backing PLATE
- 5-07205N w Brake F106
- 1-07206N w ROTOR
- 1-07207N w BOLT

**WHEEL**

- 1-04101N M/W ASSY BEB
- 2-04103N M/W I.B. BEB
- 3-04104N M/W O.B. BEB

## WHEELS/BRAKES F-111

- 1- 08101N W/H INBOARD(M) ZRP
- 2- 08102N W/H OUTBOARD(M) ZRP
- 3- 08103N DELETED
- 4- 08105N WHEEL ASSY (M) ZRP
- 5- 08106N DELETED
- 6- 08107N DELETED
- 7- 08150N W/H INBOARD (N) ZRP
- 8- 08151N WHEEL ASSY (N) ZRP
- 9- 08152N WHEEL ASSY (N) ZRP
- 10- 08153N W/H OUTBOARD (N) ZRP
- 11- 08154N W/H OUTBOARD (N) ZRP
- 12- 08155N W/H INBOARD (N) ZRP
- 12- 08108N W/H SUB ASSY O/B
- 13- 08109N W/H SUB ASSY I/B
- 14- 08110N WHEEL ASSY ZRP

## ✓ BRAKES

- 1- 08201N STATOR CARRIER
- 2- 08202N STATOR PLATE
- 3- 08203N Brake F111
- 4- 08204N Pressure PLATE
- 5- 08205N Backing PLATE
- 6- 08206N Pressure PLATE FB111
- 7- 08207N Brake FB111
- 8- 08208N Torque Tube
- 9- 08209N Torque Tube FB111
- 10- 08210N Deleted.
- 11- 08211N Rotating Disk
- 12- 08212N Backing PLATE

# WHEELS

FB-111

- 13- 08108N w/H Out Board. BEB
- 14- 08109N w/H IN Board. BEB
- 15 08110N w- ASSY BEB

WHEELS/ BRAKES  
KC-135

Pull

- 1-15101N M/W INBOARD/OUTBOARD ASSY
- 2-15102N M/W OUTBOARD ✓
- 3-15103N M/W INBOARD ✓
- 4-15150N M/W INBOARD JRP
- 5-15151N M/W OUTBOARD ✓
- 6-15152N M/W INBOARD ✓
- 7-15153N M/W ASSY ✓
- 8-15154N M/W OUTBOARD JRP
- 9-15155N M/W ASSY JRP

Pull

✓ BRAKES

- 1-15201N Backing Plate
- 2-15202N Brake KC135
- 3-15203N Brake STATOR
- 4-15204N Pressure Plate
- 5-15205N Rotor Segment

WHEELS/BRAKES  
T-33

- 1- 32102N WHEEL ASSY JAP
- 2 32101N Flange Demountable JAP
- 3 32103N Wheel Sub Assembly JAP
- 4 11101N W/H OUTBOARD MLC JAP
- 5 11103N W/H ASSY MLC JAP
- 6 11104N W/H INBOARD MLC JAP

✓ BRAKES

- 1- 32201N Brake T-33
- 32202N ROTOR

T-38

✓BRAKES

- 1-33201N Brake ASSY T-38
- 2-33203N Torque Plate
- 3-33204N Carrier & Lining
- 4-33205N Disk Plate
- 5-33202N Wear Plate



①  
C/N 15468A-15542A

(9) - ~~15468A~~  
-15359A

15101N  
15102N  
15103N  
15150N  
15151N  
15152N  
15153N  
15154N  
15155N

C/N 90101A

(16)

21101N  
21103N  
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21150N  
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21159N  
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21161N  
21162N

C/N 17576A-17575A

(102)

21096N -17578A  
21097N -74692A  
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CN 16837A -16836A  
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pg 4  
C/N 74527A

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C/N 17143A -17142A  
(26)

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16010 N x

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C/N 15828A

(3)

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(8) - 62922A

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19105 N ✓

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C/N 15592A - 15468A

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C/N 74527A - 74524A

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(33)

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19058 - 19508 N - under

17565A pg 3

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19060 - 19511 N

19061 - 19512 N

19062 - 19513 N

19063 - 19514 N

19064 - 19515 N

19065 - 19516 N

19066 - 19517 N

19067 - 19518 N

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(18)

15501 N - 17561

15502 N -

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C/N 69354A ~~contd~~

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36106 N  
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C/N 69595A - 15139A  
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16119 N

C/N 74521A -   
(33)

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C/N 17402A  
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C/N 15641A

(2)

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C/N 16019A

(27)

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C/N 17478A

(37)

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33505 NV

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33512 N

33513 N

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C/N 15068A

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16201 N

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16204 N

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C/N 25874A - 26413A

(11) - 26411A

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C/N 68521A - 62905A

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pg 10

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C/N 68521 A cmtel

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C/N 25737 A  
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37004 N  
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C/N 19844 A  
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C/N 15295 A - 15583 A  
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C/N 16915 A - 17234 A  
(82) -17327 A

15001 N -17451 A  
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15004 N -17349 A  
15005 N ✓ -17407 x  
15006 N -69554 H  
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17327A  
C/N 16915A - 17234A

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15523A  
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C/N 15161A

(5)

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C/N 15752A

(7)

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C/N 17354A

(26)

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C/N 17354A

08519 N

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08522 N

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08524 N

08525 N

08526 N

08527 N

C/N 15485A - 16266A

(15) - 16267A

01101 N

01102 N

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01104 N

01105 N

01106 N

01107 N

01108 N

01150 N

01151 N

01152 N

01153 N

01154 N

01155 N

01156 N

C/N 26338A - 26337A

(31)

36000 N

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36006 N

(9)  
C/N 26338A - 26337A

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36034 N

C/N 25425 - 15686A

(6)

38101 N

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C/N 72898 A  
(16)

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C/N 15327A - 15728A  
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- 68521A

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on pg 6

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C/N 17313A - 17339A - 69657A - 17348A  
17451A - 17327A - 17245A

(82)

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174514-17327A-17245A  
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C/N 17142A-17143A  
69855A

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C/N 16123A  
(28)

- 18400 N ✓
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- 18405 N

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C/N 16123A

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- 18429 N

C/N 74568A  
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- 13203 N
- 13204 N
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C/N 15226A-15139A -64595A  
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C/N 17474A-~~17475A~~  
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(13)

C/N 15387

(5)

33201 N

33203 N

33204 N ✓

33205 N

33202 N

C/N 72877A

(41)

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37520 N

37521 N

37522 N

37523 N

37524 N / 37524

37525 N

37526 N

C/N 42626A

(24)

16501 N

16502 N

16503 N

16504 N

16505 N

16507 N

16508 N

16509 N

16510 N

16522 N

16523 N

16524 N

16525 N

16526 N

16527 N

16528 N

16529 N

16530 N

16531 N

16532 N

16533 N

16534 N

16535 N

16536 N ✓

C/N 72896 A - 15698 A

(15)

21201 N  
21202 N  
21203 N  
21204 N  
~~21205 N deleted~~  
21206 N  
21207 N  
21208 N  
21209 N  
21210 N  
21211 N  
21212 N  
21213 N  
21214 N  
21215 N  
21216 N

17527 A chud

13017 N (F)

13018 N

13019 N

13020 N

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C/N 83317 A

(7)

37701 N

37702 N

37703 N ✓

37704 N

37705 N

37706 N

37707 N

C/N 17527 A - 17595 A

(18)

13000 N

13001 N

13002 N

13003 N

13005 N

13007 N

13009 N

13010 N

13011 N

13012 N

13013 N

13014 N

13015 N ✓

13016 N

~~C/N 26559 A - 26560 A~~  
C/N 26559 A - 26560 A  
(31) (31)

36203 N

36204 N

36205 N ✓

36206 N

36207 N

36208 N

36209 N

~~deleted~~ 36210 N

36212 N

36213 N

36214 N

36215 N ✓

36216 N

36217 N

36218 N

36219 N

36220 N

36221 N

36222 N

36223 N

36224 N ✓

36225 N

36226 N

36227 N

36228 N

36229 N

36230 N

36231 N ✓

36232 N

36233 N

36234 N

36236 N ✓

# WHEEL GROUPINGS TO BE PROCESS CHARACTERIZED

<u>FAMILY NO.</u>	<u>FAMILY CHARACTERISTICS</u>	<u>AIRCRAFT</u>	<u>PEN</u>	<u>STD. HRS.</u> <u>(MANPGP)</u>	<u>WED</u>
<i>THEMAN</i> <i>AL</i>	1 6 0 MAGNESIUM	<i>TC</i> KC-135N	15592A	2.67	151531
<i>KYLE</i>	2 6 0 ALUMINUM - LARGE	<i>TC</i> B-52M	69595A	2.47	16136A1
<i>AL</i>	3 2 0 ALUMINUM - MEDIUM (MAIN WHEELS)	"KC-135M" A-10M, C-5M C-130M, C-141M E-34M, F-4M F-5M, F-15M F-16M, F-100M F-106M, F-111M FB-111M	90101A	2.75	21101N
<i>MEL</i>	4 2 0 ALUMINUM - SMALL	<del>E-3BNE</del> A-10N, C-5N A-7N, C-130N E-3AN, F-4N	16267A	2.09	01156N

1 0 0

Jul 11 1994 - Letter L 113. W;

21

File name: WHEELS.DS, 11/11/94

NAME	ALC 00	RCC WHEELS	REMOV INSTL				ITEM NUMBER		WCD NAME	WCD DATE		SAME	
			OP #	OP #	OP #	OP #	PCN/NSN/PN	PCN/NSN/PN		INSTAL	INSTAL		
15592A	15153N	88203	5	10	15592A	15152N	88201 Y	15152N	88201 Y	88201 Y	88201 Y	88201 Y	88201 Y
15592A	15153N	88203	5	10	15592A	15151N	88210 Y	15151N	88210 Y	88210 Y	88210 Y	88210 Y	88210 Y
69595A	16106N	88245 1B	1B	10	69595A	16105N	88281 N	16105N	88281 N	88281 N	88281 N	88281 N	88281 N
69595A	16106N	1B	1B	10	69595A	16102N	88281 N	16102N	88281 N	88281 N	88281 N	88281 N	88281 N
90101A	21101N	88354 2C	2C	10	90101A	21103N	88237 N	21103N	88237 N	88237 N	88237 N	88237 N	88237 N
90101A	21101N	2C	2C	10	90101A	21104N	88237 N	21104N	88237 N	88237 N	88237 N	88237 N	88237 N
16267A	01156N	88237	5	10	16267A	01155N	88298 N	01155N	88298 N	88298 N	88298 N	88298 N	88298 N
16267A	01156N		5	10	16267A	01150N	88278 N	01150N	88278 N	88278 N	88278 N	88278 N	88278 N



File: 117EELWLDJWKJ

NAME:

ALC: UU

RLC: WHEELS

ITEM CODE	AIRCRAFT MODEL	WCU #	WL TYPE	PLANT STOCK	1st	2nd	3rd	4th	WIR #	MAX WIP	SID HRS
155Y2A	KU-135N	15152N	4	U	14	82	140	95		13/8	10.13
155Y2A	KU-135N	15152N	4	U							
155Y2A	KU-135N	15152N	4	U							
6Y5Y5A	B-52M	16106N	4	U	350	338	181	14		13/8	14.05
6Y5Y5A	B-52M	16105N	4	U							
6Y5Y5A	B-52M	16102N	4	U							
YU101A	U-5M	21101N	4	U	2298	2033	1850	1521		13/8	13.38
YU101A	U-5M	21103N	4	U							
YU101A	U-5M	22104N	4	U							
1626/A	F-4N	U1156N	4	U	260	223	330	184		13/8	7.14
1626/A	F-4N	U1155N	4	U							
1626/A	F-4N	U1150N	4	U							

NAME:  
PCN: 15592A

ALL: UU

RCC:MANPGW

WCD: 15153N

MODDATE:88713

UP #	RCC	UP	DESC	UP	UCCU	UP	MAND	FLW	SKIL	TIME	REV	EQUIP	TIME	REV
					FAC	TYPE	%	HRS	CODE	QTY	%	CODE	QTY	%
IN	MANPGW	IND			1.00	P			HBUS	1		FL0001	1	0.10
005	MANPGW	SPL			1.00	P			HBUS	2		PM0921		0.40
010	MANPGP	MICH			1.00	P			UVHD	1		PM0940	1	0.02
020	MANPGP	ASSY			1.00	P					45			45
023	MANPGP	ASSY			1.00	P					15			15
020	MANPGP	ASSY			1.00	P			YH09	1	40	WA0002	1	40
030	MANPGP	PNI			1.00	P			3S09	1	60	WA0003	1	60
030	MANPGP	PNI			1.00	P					40			40
998	MANPGP	CHK			1.00	P			3S09	1		WA0003	1	0.10
999	MANPGP	INSP			1.00	P			3S09	1		WA0003	1	0.10
9999	MANPGP	SELL			1.00	P			UVHD	1		0.02		0.10



U30A	MANPKC	U307	1.00	P	U107	1	1.00	0.08	PM5701	1	1.00	0.09
U45	MANPKA	REPR	0.25	1	JA10	1	0.02	0.02	PM5701	1	1.00	0.17
U45	MANPKA	REPR	0.25	5	JA10	1	0.17	PM7211	1	0.51	1	0.51
U45	MANPKA	REPR	0.25	P	JA10	1	0.51	PM7211	1	0.51	1	0.51
U50	MANPKA	REPR	0.05	1	JA10	1	0.02	0.02	PM2577	1	0.56	0.56
U50	MANPKA	REPR	0.05	S	JA10	1	0.56	PM2577	1	0.62	1	0.62
U50	MANPKA	REPR	0.05	P	JA10	1	0.62	PM2577	1	0.62	1	0.62
U60	MANPKA	REPR	0.80	1	JA10	1	0.02	0.02	PM2576	1	0.56	0.56
U60	MANPKA	REPR	0.80	S	JA09	1	0.56	PM2576	1	0.46	1	0.46
U60	MANPKA	REPR	0.80	P	JA09	1	0.46	PM2576	1	0.60	1	0.60
U65	MANPKC	MUVE	1.00	1	U0H0	1	0.60	FL0002	1	0.05	1	0.05
U70	MANPKC	CLN	1.00	1	UP05	1	0.05	PM4118	1	0.01	1	0.01
U70	MANPKC	CLN	1.00	S	CLN	1	0.01	CE20	1	0.01	1	0.01
U70	MANPKC	CLN	1.00	S	CLN	1	0.01	PM5681	1	0.01	1	0.01
U70	MANPKC	CLN	1.00	P	CLN	1	0.05	CE20	1	0.08	1	0.08
U70	MANPKC	CLN	1.00	P	CLN	1	0.05	PM5681	1	0.08	1	0.08
U70A	MANPKC	KINS	1.00	S	UP09	1	0.01	CE20	1	0.01	1	0.01
U70A	MANPKC	KINS	1.00	P	UP09	1	0.01	CE20	1	0.01	1	0.01
U70A	MANPKC	KINS	1.00	P	UP09	1	0.01	CE20	1	0.01	1	0.01
U70B	MANPKC	KINS	1.00	P	UP09	1	0.01	CE20	1	0.01	1	0.01
U70B	MANPKC	CLN	1.00	S	UP09	1	0.01	CE20	1	0.01	1	0.01
U70B	MANPKC	CLN	1.00	P	UP09	1	0.01	CE20	1	0.01	1	0.01
U70B	MANPKC	CLN	1.00	P	UP09	1	0.01	CE20	1	0.01	1	0.01
U70C	MANPKC	KINS	1.00	S	UP09	1	0.01	CE20	1	0.01	1	0.01
U70C	MANPKC	KINS	1.00	P	UP09	1	0.01	CE20	1	0.01	1	0.01
U70C	MANPKC	KINS	1.00	P	UP09	1	0.01	CE20	1	0.01	1	0.01
U70C	MANPKC	KINS	1.00	P	UP09	1	0.01	CE20	1	0.01	1	0.01
U70D	MANPKC	DEUX	1.00	S	UP09	1	0.01	CE20	1	0.01	1	0.01
U70D	MANPKC	DEUX	1.00	P	UP09	1	0.01	CE20	1	0.01	1	0.01
U70D	MANPKC	DEUX	1.00	P	UP09	1	0.01	CE20	1	0.01	1	0.01
U70D	MANPKC	DEUX	1.00	P	UP09	1	0.01	CE20	1	0.01	1	0.01
U70E	MANPKC	KINS	1.00	S	UP09	1	0.01	CE20	1	0.01	1	0.01
U70E	MANPKC	KINS	1.00	P	UP09	1	0.01	CE20	1	0.01	1	0.01
U70E	MANPKC	KINS	1.00	P	UP09	1	0.01	CE20	1	0.01	1	0.01
U70E	MANPKC	KINS	1.00	P	UP09	1	0.01	CE20	1	0.01	1	0.01
U70F	MANPKC	ANZ2	1.00	S	UP09	1	0.01	CE20	1	0.01	1	0.01
U70F	MANPKC	ANZ2	1.00	P	UP09	1	0.01	CE20	1	0.01	1	0.01
U70F	MANPKC	ANZ2	1.00	P	UP09	1	0.01	CE20	1	0.01	1	0.01
U70G	MANPKC	KINS	1.00	S	UP09	1	0.01	CE20				

100	MANP6P	LUMU	1.00	P	SSUY	1	U.04	F10722	1	U.04
100A	MANP6P	WASH	1.00	P	SSUY	1	U.01	F10722	1	U.01
100B	MANP6P	PRIM	1.00	P	SSUY	1	U.02	F10722	1	U.02
100B	MANP6P	PRIM	1.00	P				F10438	1	U.02
100C	MANP6P	DRY	1.00	P	1			F10722	1	1.00
100E	MANP6P	PN11	1.00	P	SSUY	1	U.02	F10722	1	U.02
100E	MANP6P	PN11	1.00	P				F10438	1	U.02
100F	MANP6P	PN12	1.00	P		1	U.02	F10722	1	U.02
100F	MANP6P	PN12	1.00	P				F10437	1	U.02
100G	MANP6P	DRY	1.00	P	U.S			F10722	1	U.02
100H	MANP6P	SRP	1.00	P	YHUY	1	U.03	F10722	1	U.03
100I	MANP6P	UNLD	1.00	P				F10722	1	U.03
120	MANP6P	INSI	1.00	P				F10722	1	U.10
120	MANP6P	INSI	1.00	P	YHUY	1	U.10	F10722	1	U.10
120	MANP6P	INSI	1.00	P				F10722	1	U.10



U004	U005	U006	U007	U008	U009	U010	U011	U012	U013	U014	U015	U016	U017	U018	U019	U020	U021	U022	U023	U024	U025	U026	U027	U028	U029	U030	U031	U032	U033	U034	U035	U036	U037	U038	U039	U040	U041	U042	U043	U044	U045	U046	U047	U048	U049	U050	U051	U052	U053	U054	U055	U056	U057	U058	U059	U060	U061	U062	U063	U064	U065	U066	U067	U068	U069	U070	U071	U072	U073	U074	U075	U076	U077	U078	U079	U080	U081	U082	U083	U084	U085	U086	U087	U088	U089	U090	U091	U092	U093	U094	U095	U096	U097	U098	U099	U100	U101	U102	U103	U104	U105	U106	U107	U108	U109	U110	U111	U112	U113	U114	U115	U116	U117	U118	U119	U120	U121	U122	U123	U124	U125	U126	U127	U128	U129	U130	U131	U132	U133	U134	U135	U136	U137	U138	U139	U140	U141	U142	U143	U144	U145	U146	U147	U148	U149	U150	U151	U152	U153	U154	U155	U156	U157	U158	U159	U160	U161	U162	U163	U164	U165	U166	U167	U168	U169	U170	U171	U172	U173	U174	U175	U176	U177	U178	U179	U180	U181	U182	U183	U184	U185	U186	U187	U188	U189	U190	U191	U192	U193	U194	U195	U196	U197	U198	U199	U200	U201	U202	U203	U204	U205	U206	U207	U208	U209	U210	U211	U212	U213	U214	U215	U216	U217	U218	U219	U220	U221	U222	U223	U224	U225	U226	U227	U228	U229	U230	U231	U232	U233	U234	U235	U236	U237	U238	U239	U240	U241	U242	U243	U244	U245	U246	U247	U248	U249	U250	U251	U252	U253	U254	U255	U256	U257	U258	U259	U260	U261	U262	U263	U264	U265	U266	U267	U268	U269	U270	U271	U272	U273	U274	U275	U276	U277	U278	U279	U280	U281	U282	U283	U284	U285	U286	U287	U288	U289	U290	U291	U292	U293	U294	U295	U296	U297	U298	U299	U300	U301	U302	U303	U304	U305	U306	U307	U308	U309	U310	U311	U312	U313	U314	U315	U316	U317	U318	U319	U320	U321	U322	U323	U324	U325	U326	U327	U328	U329	U330	U331	U332	U333	U334	U335	U336	U337	U338	U339	U340	U341	U342	U343	U344	U345	U346	U347	U348	U349	U350	U351	U352	U353	U354	U355	U356	U357	U358	U359	U360	U361	U362	U363	U364	U365	U366	U367	U368	U369	U370	U371	U372	U373	U374	U375	U376	U377	U378	U379	U380	U381	U382	U383	U384	U385	U386	U387	U388	U389	U390	U391	U392	U393	U394	U395	U396	U397	U398	U399	U400	U401	U402	U403	U404	U405	U406	U407	U408	U409	U410	U411	U412	U413	U414	U415	U416	U417	U418	U419	U420	U421	U422	U423	U424	U425	U426	U427	U428	U429	U430	U431	U432	U433	U434	U435	U436	U437	U438	U439	U440	U441	U442	U443	U444	U445	U446	U447	U448	U449	U450	U451	U452	U453	U454	U455	U456	U457</
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1004	MANIPGP	1.00	P	3SU7	1	U.01	PMU722	1	U.01
1004	MANIPGP	1.00	P	3SU7		U.02	PMU722	1	U.02
1008	MANIPGP	1.00	P				PMU438	1	U.02
1008	MANIPGP	1.00	P				PMU722	1	1.00
100C	MANIPGP	1.00	P				PMU722	1	U.02
100D	MANIPGP	1.00	P	3SU7	1	U.02	PMU436	1	U.02
100E	MANIPGP	1.00	P				PMU722	1	U.02
100F	MANIPGP	1.00	P				PMU722	1	U.02
100F	MANIPGP	1.00	P	3SU7	1	U.02	PMU722	1	U.02
100F	MANIPGP	1.00	P	3SU7	1	U.02	PMU437	1	U.02
100G	MANIPGP	1.00	P	U.S			PMU722	1	U.00
100H	MANIPGP	1.00	P	YHUY	1	U.03	PMU722	1	U.03
100I	MANIPGP	1.00	P				PMU757	1	U.10
100I	MANIPGP	1.00	P				PMU740	1	U.10
120	MANIPGP	1.00	P	YHUY	1	U.10	WAAUUU4	1	U.10
120	MANIPGP	1.00	P						



NAME: PCN: 16267A

ALC: UU RCU:WHEELS

WCD: 01106 WCDDATE:88237

UP #	RCU	UP DESC	UP FAC	UP TYPE	UP MAND	FLW HRS	SKIL CODE	TIME %	TIME HRS	REK HRS	EQUP CODE	QTY	%	TIME HRS	REK HRS
001	MANPGR	IND	1.00	P			HB07	1	0.10	0.10	FL0001	1		0.10	0.10
005	MANPGR	SPLI	1.00	P			HB09	2	0.20	0.20	PM0921	1		0.20	0.20
010	MANPGR	MICH	1.00	P			UVHD	1	0.02	0.02	PM0940	1		0.02	0.02
015	MANPGR	ASSY	1.00	P			YH09	1	0.18	0.18	WA0002	1		0.18	0.18
020	MANPGR	PNT	1.00	P			3S09	1	0.18	0.18	WA0003	1		0.18	0.18
997	MANPGR	DCM1	1.00	P			3S09	1	0.10	0.10	WA0003	1		0.10	0.10
998	MANPGR	INSP	1.00	P			3S09	1	0.10	0.10	WA0003	1		0.10	0.10
999	MANPGR	SELL	1.00	P			UVHD	1	0.02	0.02					

FILE NAME:

File name: 01106N, 101

File: 10-11-11

File name: 161214, Wk.

ALL: UN

5:17:44M: 77M

187.88:31400.71 NJ71:91:0700

187.88: 71407.717

**NAME :**

PLN: 64543N

UP	KCU	UP	DESC	UCLU	UP	MANU	FLOW	SKIL	UTIL	TIME	EQUIP	QTY	TIME	REQ		
#				TYPE	%	HRS		CODE		%	CODE		%	HRS		
UU05	MANP'GW	UTS	1.00	P				HB05		1	100	0.08	PMU0921	1	100	0.08
UU05A	MANP'GW	TRANS	1.00	I							PMU0921	1	100	0.08		
UU05B	MANP'GW	LUAD	1.00	P				HB05		1	100	0.04	PMU0426	1	100	0.04
UU05C	MANP'GW	PRUC	1.00	P	100	0.5					PMU0426	1	100	0.50		
UU05D	MANP'GW	UNLD	1.00	I							PMU0921	1	100	0.08		
UU05E	MANP'GW	UNLD	1.00	P				HB05		1	100	0.08	PMU0426	1	100	0.08
UU06	MANP'GW	REM	1.00	S				HB05		1	100	0.04	HB0001	1	100	0.04
UU06	MANP'GW	REM	1.00	P				HB05		1	100	0.04	HB0001	1	100	0.04
UU06A	MANP'GW	LUAD	1.00	I							PMU0921	1	100	0.08		
UU06A	MANP'GW	LUAD	1.00	P				K105		1	100	0.08	PMU0901	1	100	0.08
UU07	MANP'GW	PRUC	1.00	I							PMU0901	1	100	3.43		
UU07	MANP'GW	PRUC	1.00	S				K105		1	100	0.08				
UU07	MANP'GW	PRUC	1.00	P	100	2.87					PMU0616	1	100	3.47		
UU07A	MANP'GW	UNLD	1.00	I							PMU0901	1	100	0.08		
UU07A	MANP'GW	UNLD	1.00	P				K105		1	100	0.08	CU00002	1	100	0.08
UU07B	MANP'GW	LUAD	1.00	I							CU00002	1	100	0.02		
UU07B	MANP'GW	LUAD	1.00	P				K105		1	100	0.08	PMU0416	1	100	0.08
UU0Y	MANP'GW	CLN	1.00	S				K105		1	100	0.05				
UU0Y	MANP'GW	CLN	1.00	P				K105		1	20	0.15	PMU0416	1	20	0.15
UU0Y	MANP'GW	CLN	1.00	P				K105		1	80	0.25	PMU0416	1	80	0.25
UU0YA	MANP'GW	UNLD	1.00	I							CU00002					
UU0YA	MANP'GW	UNLD	1.00	P				K105		1	100	0.04	PMU0416	1	100	0.04
UU0YB	MANP'GW	LUAD	1.00	I							CU00002					
UU0YB	MANP'GW	LUAD	1.00	P				K105		1	100	0.08	PMU0901	1	100	0.08
UU0YB	MANP'GW	REMV	0.07	I				JAU7		1	100	0.06				
UU0YB	MANP'GW	REMV	0.07	S				JAU0		1	1.04	PM0197	1	1.04	1.04	
UU0YB	MANP'GW	REMV	0.07	P				JAU0		1	0.85	PM0197	1	0.85	0.85	
UU11	MANP'GW	CLN	0.10	I							CU00002	1	100	0.05		
UU11	MANP'GW	CLN	0.10	I							PMU0901	1	100	0.08		
UU11	MANP'GW	CLN	0.10	S				K105		1	100	0.05				
UU11	MANP'GW	CLN	0.10	P				K105		1	80	0.05	PMU0416	1	80	0.05
UU11	MANP'GW	CLN	0.10	P				K105		1	20	0.10	PMU0416	1	20	0.10
UU12	MANP'GW	PRUC	1.00	I							PMU0901	1	100	1.03		
UU12	MANP'GW	PRUC	1.00	S				K105		1	100	0.08				
UU12	MANP'GW	PRUC	1.00	P	100	0.86					PM0590	1	100	1.03		
UU15	MANP'NA	FP1	0.75	I							PMU0901	1	100	0.02		
UU15	MANP'NA	FP1	0.75	P				DB0Y		2	0.05	PMU0901	1	1.05	1.05	
UU15	MANP'NA	FP1	0.75	P							PMU069E	1	1.05	1.05		
UU15A	MANP'NA	FP1	0.25	I							PMU0901	1	0.02	1	0.02	
UU15A	MANP'NA	FP1	0.25	P							PMU0901	1	1.10	1.10		
UU15A	MANP'NA	FP1	0.25	P				DB0Y		1	0.10	PMU0901	1	1.10	1.10	
UU16	MANP'GW	UNLD	1.00	P				K105		1	100	0.08	PMU0901	1	100	0.08
UU16A	MANP'GW	LUAD	1.00	P				K105		1	100	0.05	CU00002	1	100	0.05
UU1Y	MANP'GW	CLN	1.00	I							CU00002	1	100	0.08		
UU1Y	MANP'GW	CLN	1.00	P				K105		1	80	0.50	PMU0410	1	80	0.50
UU1Y	MANP'GW	CLN	1.00	P				K105		1	20	0.75	PMU0410	1	20	0.75
UU1YA	MANP'GW	TRANS	1.00	I							CU00002	1	100	0.08		

[illegible]



File name: 16106 N.

File no: 16106011-21

NAME: ACAC  
RUN: 6Y3Y3A

ALU: 00

STJTHM:774

WLD: 16116N WLDHLE:88245

WCD: 16116N

WUDDALE:88245

[illegible]

File name

File name 21101N, 1/1/1

NAME :			ALC: UU			KUC:WHEELS			WCD: 21101N			WCD DATE: 88354			
UP	#	KUC	UP	DESC	UP	UCCU	FAC	UP	MAND	FLW	SKIL	TIME	REK	TIME	REK
					TYPE	%				HRS	CODE	WY	%	HRS	
UUS	MANPUS		IND	1.00	P			HBUS				1	100	0.08	0.08
UUS	MANPUS		LUAD	1.00	I										
UUS	MANPUS		LUAD	1.00	P			HBUS				1	100	0.03	0.03
UUS	MANPUS		KEM	1.00	P			HBUS				1	100	0.03	0.03
UUS	MANPUS		KEM	1.00	P			HBUS				1	100	0.03	0.03
UUS	MANPUS		KEM	1.00	P			HBUS				1	100	0.03	0.03
UUS	MANPUS		KEM	1.00	P			HBUS				1	80	0.15	0.15
UUS	MANPUS		KEM	1.00	P			HBUS				1	20	0.08	0.08
UUS	MANPUS		KEM	1.00	P			HBUS				1	100	0.08	0.08
UUS	MANPUS		KEM	1.00	P			HBUS				1	100	0.08	0.08
UUS	MANPUS		KEM	1.00	P			HBUS				1	100	0.08	0.08
UUS	MANPUS		SPLI	1.00	P			HBUS				2	100	0.08	0.08
UUS	MANPUS		MAIC	1.00	P			UWHD				1		0.02	0.02
UUS	MANPUS		ASSY	1.00	P									2.00	2.00
UUS	MANPUS		ASSY	1.00	P			YHUY				1	40	0.30	0.30
UUS	MANPUS		ASSY	1.00	P									30	30
UUS	MANPUS		IPNI	1.00	P			35UY				1		0.10	0.10
UUS	MANPUS		FINA	1.00	P			35UY				1		0.10	0.10
UUS	MANPUS		FINA	1.00	P			35UY				1		0.10	0.10
UUS	MANPUS		SELL	1.00	P										



[illegible]



70

NAME: YULIA  
PUNK: YULIA

ALL: UN

STATHM: 77.4

WLD: 117: 0.7M  
N41117: 0.7M  
WLD: 117: 0.7M

UP #	KCU	UP DESC	UCCU PAC	UP TYPE %	UP MAND	FLOW HRS	SKIL CODE	TIME WTY %	REK HRS	EQUIP CODE	TIME WTY %	REK HRS
U05	MANPFW	U15	1.00 P				HBUS	1 100	0.08	PMU921	1 100	0.08
U05A	MANPFW	IMANS	1.00 I							PMU921	1 100	0.08
U05B	MANPFW	LUAD	1.00 P				HBUS	1 100	0.04	PMU426	1 100	0.04
U05C	MANPFW	PKUC	1.00 P	100	U.5					PMU426	1 100	0.50
U05D	MANPFW	UNLD	1.00 I							PMU921	1 100	0.08
U05E	MANPFW	UNLD	1.00 P				HBUS	1 100	0.08	PMU426	1 100	0.08
U06	MANPFW	REM	1.00 S				HBUS	1 100	0.04			
U06A	MANPFW	REM	1.00 P				HBUS	1 100	0.04	PMU001	1 100	0.04
U06B	MANPFW	LUAD	1.00 I				HBUS	1 100	0.08	PMU921	1 100	0.08
U06C	MANPFW	LUAD	1.00 P				KIUS	1 100	0.08	PMU901	1 100	0.08
U06D	MANPFW	PKUC	1.00 I							PMU901	1 100	2.89
U06E	MANPFW	PKUC	1.00 S				KIUS	1 100	0.08			
U06F	MANPFW	PKUC	1.00 P	100	2.89					PMU616	1 100	2.89
U06G	MANPFW	UNLD	1.00 I							PMU901	1 100	0.08
U06H	MANPFW	UNLD	1.00 P				KIUS	1 100	0.08	CUUU02	1 100	0.08
U06I	MANPFW	LUAD	1.00 I				KIUS	1 100	0.03	CUUU02	1 100	0.03
U06J	MANPFW	LUAD	1.00 P				KIUS	1 100	0.04	PMU416	1 100	0.03
U06K	MANPFW	CLN	1.00 S				KIUS	1 100	0.16	PMU416	1 50	0.16
U06L	MANPFW	CLN	1.00 P				KIUS	1 50	0.08	PMU416	1 50	0.08
U06M	MANPFW	CLN	1.00 P				KIUS	1 100	0.08	PMU901	1 100	0.08
U06N	MANPFW	LUAD	1.00 P				KIUS	1 100	0.08	PMU901	1 100	1.03
U06O	MANPFW	PKUC	1.00 I							PMU901	1 100	1.03
U06P	MANPFW	PKUC	1.00 S				KIUS	1 100	0.08			
U06Q	MANPFW	PKUC	1.00 P	100	0.86					PMU690	1 100	1.03
U06R	MANPFW	PMU	0.75 I							PMU901	1	0.02
U06S	MANPFW	PMU	0.75 P				DBUY	2	0.05	PMU901	1	1.05
U06T	MANPFW	PMU	0.75 P							PMU69/E	1	1.05
U06U	MANPFW	PMU	0.25 I							PMU901	1	0.02
U06V	MANPFW	PMU	0.25 P							PMU69/E	1	1.10
U06W	MANPFW	PMU	0.25 P				DBUY	1	0.10	PMU901	1	1.10
U06X	MANPFW	UNLD	1.00 I							CUUU02	1 100	0.04
U06Y	MANPFW	UNLD	1.00 P				KIUS	1 100	0.04	PMU901	1 100	0.04
U06Z	MANPFW	LUAD	1.00 S				KIUS	1 100	0.04	PMU410	1 100	0.04
U07	MANPFW	CLN	1.00 P				KIUS	1 50	0.25	PMU410	1 50	0.25
U07A	MANPFW	CLN	1.00 P				KIUS	1 50	0.15	PMU410	1 50	0.15
U07B	MANPFW	UNLD	1.00 I				KIUS	1 100	0.05	CUUU02	1 100	0.08
U07C	MANPFW	UNLD	1.00 P				KIUS	1 100	0.05	PMU410	1 100	0.08
U07D	MANPFW	IMANS	1.00 I							CUUU02	1 100	0.08
U07E	MANPFW	INSP	1.00 P				DIU7	1 40	0.15			
U07F	MANPFW	INSP	1.00 P				DIU7	1 60	0.35			
U07G	MANPFW	LUAD	1.00 P				DIU7	1 100	0.08	PMU901	1 100	0.08
U07H	MANPFW	IMRD	0.05 I			0.06	JAU7	1	0.06			
U07I	MANPFW	IMRD	0.05 S			0.28	JAU7	1	0.28	PMZ5/6	1	0.28
U07J	MANPFW	IMRD	0.05 P			0.84	JAU7	1	0.84	PMZ5/6	1	0.84
U07K	MANPFW	REMU	0.05 I			0.02	JAU8	1	0.02			
U07L	MANPFW	REMU	0.05 S			0.28	JAU8	1	0.28			
U07M	MANPFW	REMU	0.05 P			0.34	JAU8	1	0.34			
U07N	MANPFW	REMU	0.05 I			0.02	JAU8	1	0.02			
U07O	MANPFW	REMU	0.05 S			0.02	JAU8	1	0.02			
U07P	MANPFW	REMU	0.05 P			0.02	JAU8	1	0.02			

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100	MANPGR	INSI	U.10	U.00	YHUY	1	U.00	PM1500	1	U.00
101	MANPGR	MAUH	U.05	U.02	JH10	1	U.02		1	U.00
102	MANPGR	MAUH	U.05	U.24	JH10	1	U.24	PM1500	1	U.24
103	MANPGR	MAUH	U.05	U.05	JH10	1	U.05	PM1500	1	U.05
104	MANPGR	INSI	U.05	U.02	JHUY	1	U.02		1	U.02
105	MANPGR	INSI	U.05	U.10	JHUY	1	U.10	PM1500	1	U.10
106	MANPGR	INSI	U.05	U.08	JHUY	1	U.08	PM1500	1	U.08
107	MANPGR	INSI	U.05	U.02	JHUY	1	U.02		1	U.02
108	MANPGR	INSI	U.05	U.31	JHUY	1	U.31		1	U.31
109	MANPGR	INSI	U.05	U.43	JHUY	1	U.43		1	U.43
110	MANPGR	MUVE	U.00	U.10	U.00	1	U.10	PM1500	1	U.10
111	MANPGR	LUAD	U.00	U.10	YHUY	1	U.10	PM1500	1	U.10
112	MANPGR	HEAT	U.00	U.00	YHUY	1	U.00		1	U.00
113	MANPGR	HEAT	U.00	U.00	YHUY	1	U.00		1	U.00
114	MANPGR	INSI	U.00	U.01	YHUY	1	U.01	PM1500	1	U.01
115	MANPGR	UNLD	U.00	U.01	YHUY	1	U.01	PM1500	1	U.01
116	MANPGR	LUAD	U.00	U.01	YHUY	1	U.01	PM1500	1	U.01
117	MANPGR	WASH	U.00	U.01	YHUY	1	U.01	PM1500	1	U.01
118	MANPGR	WASH	U.00	U.01	YHUY	1	U.01	PM1500	1	U.01
119	MANPGR	WASH	U.00	U.01	YHUY	1	U.01	PM1500	1	U.01
120	MANPGR	WASH	U.00	U.01	YHUY	1	U.01	PM1500	1	U.01
121	MANPGR	WASH	U.00	U.01	YHUY	1	U.01	PM1500	1	U.01
122	MANPGR	WASH	U.00	U.01	YHUY	1	U.01	PM1500	1	U.01
123	MANPGR	WASH	U.00	U.01	YHUY	1	U.01	PM1500	1	U.01
124	MANPGR	WASH	U.00	U.01	YHUY	1	U.01	PM1500	1	U.01
125	MANPGR	WASH	U.00	U.01	YHUY	1	U.01	PM1500	1	U.01
126	MANPGR	WASH	U.00	U.01	YHUY	1	U.01	PM1500	1	U.01
127	MANPGR	WASH	U.00	U.01	YHUY	1	U.01	PM1500	1	U.01
128	MANPGR	WASH	U.00	U.01	YHUY	1	U.01	PM1500	1	U.01
129	MANPGR	WASH	U.00	U.01	YHUY	1	U.01	PM1500	1	U.01
130	MANPGR	WASH	U.00	U.01	YHUY	1	U.01	PM1500	1	U.01



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[illegible]





U4UA	MANPFW	LUAD	1.00	1	U1U	0.08	0.00002	1	100	0.000
U4UA	MANPFW	LUAD	1.00	F	U4UY	0.06	PMU7U1	1	100	0.000
U47	KA	META	0.05	1						
U47	MANPRA	META	0.05	S	U4UY	0.28	PM51Y7	1		0.200
U47	MANPRA	META	0.05	F	U4UY	0.00	PM51Y7	1		0.000
U6U	MANPRA	KEAM	0.46	1	U41U	0.02				
U6U	MANPRA	KEAM	0.46	S	U41U	0.06	PM51Y7	1		0.000
U6U	MANPRA	KEAM	0.46	F	U41U	2.12	PM51Y7	1		2.112
U7U	MANPRA	MACH	0.05	1	U41U	0.02				
U7U	MANPRA	MACH	0.05	S	U41U	0.00	PM4136	1		0.000
U7U	MANPRA	MACH	0.05	F	U41U	0.01	PM4136	1		0.001
U7UA	MANPFW	LN	0.46	1	HBUD	0.02	PMU7U1	1		0.000
U7UA	MANPFW	LN	0.46	F		0.25	PMU7U1	1		0.000
U8U	MANPRA	FPI	0.46	1			PMU7U1	1		0.002
U8U	MANPRA	FPI	0.46	F			PMU6.9E	1		1.000
U8U	MANPRA	FPI	0.46	F	U6UY	0.10	PMU7U1	1		1.000
U9U	MANPRA	BEAK	1.00	1	U41U	0.02				
U9U	MANPRA	BEAK	1.00	S	U41U	1.04	PM51Y7	1		1.004
U9U	MANPRA	BEAK	1.00	F	U41U	0.8Y	PM51Y7	1		0.8Y
11U	MANPRA	BEAK	1.00	1	U41U	0.02				
11U	MANPRA	BEAK	1.00	S	U41U	1.04	PM51Y7	1		1.004
11U	MANPRA	BEAK	1.00	F	U41U	0.83	PM51Y7	1		0.83
13U	MANPRA	KEPA	0.46	1	U41U	0.02				
13U	MANPRA	KEPA	0.46	S	U41U	0.06	PM51Y7	1		0.000
13U	MANPRA	KEPA	0.46	F	U41U	5.31	PM51Y7	1		2.31
14U	MANPRA	BEAK	0.46	1	U41U	0.02				
14U	MANPRA	BEAK	0.46	S	U41U	0.80	PM2576	1		0.800
14U	MANPRA	BEAK	0.46	F	U41U	0.7Y	PM2576	1		0.7Y
17U	MANPFW	UUMN	1.00	1	HBUD	0.00				
17U	MANPFW	PRUC	1.00	1			PMU7U1	1	100	1.200
17U	MANPFW	PRUC	1.00	S	KIUD	0.08				
17U	MANPFW	PRUC	1.00	F	100	1.00				
17U	MANPFW	UUMN	1.00	F	HBUD		HU00U1	1	100	1.200
18U	MANPFW	LUAD	1.00	F	Y6UY	0.10	PMU7U1	1		0.000
18UA	MANPFW	LN	1.00	F	0.8	Y6UY	0.00	PMU313	1	0.000
18UB	MANPFW	PRUC	1.00	S	Y6UY	1.5	PM1342	1		1.000
18UB	MANPFW	PRUC	1.00	F	Y6UY	0.10	PM1342	1		0.100
18UC	MANPFW	LN	1.00	F	Y6UY	0.10	PM6013	1		0.100
18UD	MANPFW	LUKE	1.00	F	Y6UY	1.3	PM6014	1		0.100
18UE	MANPFW	LN	1.00	F	Y6UY	0.3	U1U0U1	1		1.000
18UE	MANPFW	LN	1.00	F	0.3	Y6UY	0.10	PMU3U3	1	0.200
19U	MANPRA	INSI	1.00	1	JAUB	0.02	PM6012	1		0.100
19U	MANPRA	INSI	1.00	S	JAUB	0.1Y	PM5685			0.1Y
19U	MANPRA	INSI	1.00	F	JAUB	0.08	PM5685			0.08
19S	MANPRA	MACH	1.00	1	U41U	0.02				
19S	MANPRA	MACH	1.00	S	U41U	0.00	PM7276	1		0.000
19S	MANPRA	MACH	1.00	F	U41U	0.24	PM7276	1		0.24
20U	MANPRA	INSI	1.00	1	U4UY	0.02				
20U	MANPRA	INSI	1.00	S	U4UY	0.1Y	PM5685	1		0.1Y
20U	MANPRA	INSI	1.00	F	U4UY	0.08	PM5685	1		0.08
20S	MANPRA	INSI	1.00	1	U4UY	0.02				
20S	MANPRA	INSI	1.00	S	U4UY	0.1Y	PM5685	1		0.1Y
20S	MANPRA	INSI	1.00	F	U4UY	0.08	PM5685	1		0.08
21U	MANPRA	MACH	1.00	1	U41U	0.02				
21U	MANPRA	MACH	1.00	S	U41U	0.00	PM7276	1		0.000
21U	MANPRA	MACH	1.00	F	U41U	0.24	PM7276	1		0.24
21S	MANPRA	INSI	1.00	1	U4UY	0.02				
21S	MANPRA	INSI	1.00	F	U4UY	0.1Y	PM5685	1		0.1Y

TH0Y	1	0.01	PM0Y22	1	0.01
TH0Y	1	0.01	PM0Y35	1	0.10
SS0Y	1	0.01	PM0Y22	1	0.01
SS0Y	1	0.01	PM0Y22	1	0.02
SS0Y	1	0.01	PM0Y35	1	0.01
SS0Y	1	0.01	PM0Y22	1	0.01
SS0Y	1	0.02	PM0Y35	1	0.02
SS0Y	1	0.01	PM0Y22	1	1.00
SS0Y	1	0.01	PM0Y22	1	0.01
SS0Y	1	0.02	PM0Y35	1	0.02
SS0Y	1	0.02	PM0Y22	1	0.02
SS0Y	1	0.02	PM0Y37	1	0.02
SS0Y	1	0.02	PM0Y22	1	0.02
TH0Y	1	0.02	PM0Y22	1	0.50
TH0Y	1	0.02	PM0Y22	1	0.02
TH0Y	1	0.02	PM0Y37	1	0.10
TH0Y	1	0.20	WB0001	1	20
TH0Y	1	0.00		30	0.00
TH0Y	1	0.10		50	0.10
TH0Y	1	0.10	WB0004	1	0.10

KC-135 NLG NOSE WHEEL

## BILL OF MATERIALS

15592A

III  
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[illegible]

CONTROL NUMBER LIST

ABC	IN	CONTROL JOP	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDER	G019
		NUMBER	DESC					FLOW DAYS
ENS	RIGB	15585A	-J	F-106 MLG	BRAKE ASSY	1630-00-165-1029	151806-2	481-4-223 24
ENS	RIGB	15587A	-G-J	F-111 MLG	BRAKE PRESSURE PLATE	1630-00-264-0752	329-16-1	481-2-483 19
ENS	PRIC	15592A	-G-J	KC-135 MLG	WHEEL	1630-00-421-0319	211A243M3	4M3-7-113 30
ENS	RIGB	15601A	-G-J	T-39 MLG	BRAKE ASSY	1630-00-553-4734	9550338-1	481-2-1073 28
ENS	RIGB	15603A	-G-J	KC-135 MLG	BRAKE BACKING PLATE	1630-00-591-8349	2601844	481-4-263 16
ENS	RIGB	15616A	-J	C-141 MLG	BRAKE BACKING PLATE	1630-00-567-8162	9533668	481-2-373 19
ENS	RIGB	15621A	-J	F-106 MLG	BRAKE PRESSURE PLATE	1630-00-671-2838	151804	481-4-223 16
ENS	RIGB	15639A	-G-J	C-130 MLG	BRAKE PRESSURE PLATE	1630-01-005-4188	5002564	481-2-1003 16
ENS	RIGB	15641A	-J	F-4 MLG	BRAKE HOUSING SUB ASSY	1630-00-276-9849	5001896	481-2-1093 23
ENS	RIGB	15642A	-G-J	C-130 MLG	BRAKE BACKING PLATE	1630-01-005-4189	5000263	481-2-1003 19
ELE		15643A	-G-J	F-15 MLG	WHEEL	1630-00-123-8803	17 OCT 88	4M1-8-73 22
ENS	RIGB	15644A	-J	F-15 MG A/B	BRAKE HOUSING	1630-00-123-8806	5002269	481-2-1123 16
DOP	PRIC	15651A	-J	F-15 MLG	WHEEL	1630-00-558-2584	5000960-2	4M3-8-23 20
ENS	PRIC	15652A	-G-J	F-15 MLG	WHEEL	1630-01-005-4262	5000864	4M1-8-73 20
ENS	COOP	15677A		A-7 MLG	STRUT ASSY	1620-01-174-1655	8121017-30	4S1-90-3 30
ENS	COOP	15678A		A-7 MLG	STRUT ASSY	1620-01-174-3170	8121017-10	4S1-90-3 0
ENS	PRIC	15686A	-G-J	A-10 MLG	WHEEL	1630-00-596-9637	3-1358	4M3-4-433 16
ENS	RIGB	15698A	-G-J	C-5A MLG	BRAKE ASSY	1630-01-041-4570	2-1179-4	481-2-1063 26
ENS	RIGB	15728A	-J	C-130 MLG	BRAKE HOUSING	1630-00-937-6604	9543433	481-2-1003 16
ENS	RIGB	15744A	-J	F-15 MG A/B	BRAKE ASSY	1630-01-050-5274	5000913-12	481-2-1123 13
ENS	RIGB	15746A	-J	C-141 MLG	WHEEL	1630-01-081-6687	3-1095	4M3-7-1043 20
ENS	RIGB	15747A	-J	F-15 MLG	BRAKE BACKING PLATE	1630-00-132-2821	5002483	481-2-1123 16
ENS	RIGB	15749A	-J	F-5 MLG	BRAKE ASSY	1630-00-227-2000	AA318196	481-2-453 20
ENS	RIGB	15752A	-G-J	A-10 MLG	BRAKE ASSY	1630-01-062-7046	5002372-5	481-2-1143 27
ENS	PRIC	15753A	-J	E-3A MLG	WHEEL	1620-01-009-8474	95605718	4M1-7-1353 20
ENS	PRIC	15757A	-G-J	C-130 MLG	WHEEL	1630-00-914-1329	219A967	4M3-4-363 23
ART	SHEL	15803A	-G	A-7	HOUSING TRANSFER UNIT	1005-00-239-2929	175F631	11W1-7-1-103 20
ART	SHEL	15819A			BREECH MAU-12	1095-00-911-8407	64H13212-3	11B29-3-25-2 12
ENS	PRIC	15822A	-J	F-5 MLG	WHEEL	1630-01-055-5056	250-A-160-C	4M1-1-63 20
ENS	PRIC	15828A	-J	F-16 MLG	WHEEL	1630-01-038-9239	5003062	4M1-7-1363 20
ENS	COOP	15834A		F-16 MLG	PIN ASSY	1620-01-071-0536	2006004-103	4S1-109-3 0
ART	SHEL	15849A		MULTIPLE	AIR FOIL MXU02A/B	1325-00-162-0244	689898-2	11K1-9-3 20
DOP	COOP	15862A		F-16 MLG	PISTON ASSY	1620-01-071-0538	2006002-103	4S2-00-3 35
DOP	POLL	15865A		C-141 MLG	FORWARD LINK	1620-00-927-2601	3610013-111	4S1-73-3 21
DOP	COOP	15866A		C-111 MLG	STRUT ASSY H/W	1620-01-103-7747	7729965-10	4S1-07-3 32
ELE		15874A	-G-J	A-37 MLG	BRAKE HOUSING	1630-01-124-2873	10 OCT 88	481-2-1023 20
DOP	COOP	15984A		F-111 MLG	PIN SHOCK STRUT	1620-00-400-1007	12L9519-5	4A4-15-3 30
ENS	POLL	15998A		C-130 MLG	STRUT ASSY	1620-01-146-5708	7926623-10	4S2-23-3 65
DNR	ANDE	16019A	-J	F-4 MLG	STRUT ASSY	1620-01-024-8844	53-45400-301	4S2-57-3 69
ART	SHEL	16039A		F-16	ECM ADAPTER	1560-01-142-6594MF	16S601-819	16W6-35-3-2 15
ART	SHEL	16099A		MULTIPLE	LAU-100 LANCHR R/H AIM 9	1440-01-104-0368AB	7839472-60	11L1-3-11 7
ARK	ANDE	16101A		LGM-30	T.E. ACTUATOR	1450-00-089-0946AH	67029921-10	35D3-11-25-13 28
ENS	POLL	16123A	-G-J	C-130	BALLSCREW	1620-00-677-6681	16S0E412	16S3-2-48-23 20
ENS	RIGB	16136A		E-3A MLG	BRAKE TORQUE TUBE	1630-01-034-5387	9542482	481-2-1153 13
ART	SHEL	16148A		F-4	CENTERLINE ADAPTER ASSY	1095-00-192-5341BF	53-73023-321	1F4C-3-1-4 16
ART	SHEL	16228A		MULTIPLE	AIRFOIL MXU 602	1325-00-491-0006	689898-1	11K1-9-3 10
ART	SHEL	16229A		MULTIPLE	AIRFOIL MXU 600	1325-00-491-0007	700924-1	11F1-9-3 10
		16264A		KC-135 MLG	BRAKE COLLAR	1620-00-670-6602	69-1172-1	4A4-12-23 45
		16266A	-G-J	F-4 MLG	WHEEL	1630-00-730-0126	3-1185	4M3-7-1103 19
ENS	PRIC	16267A	-G-J	F-4 MLG	WHEEL	1630-00-852-1432	220A123	4M3-7-1143 19

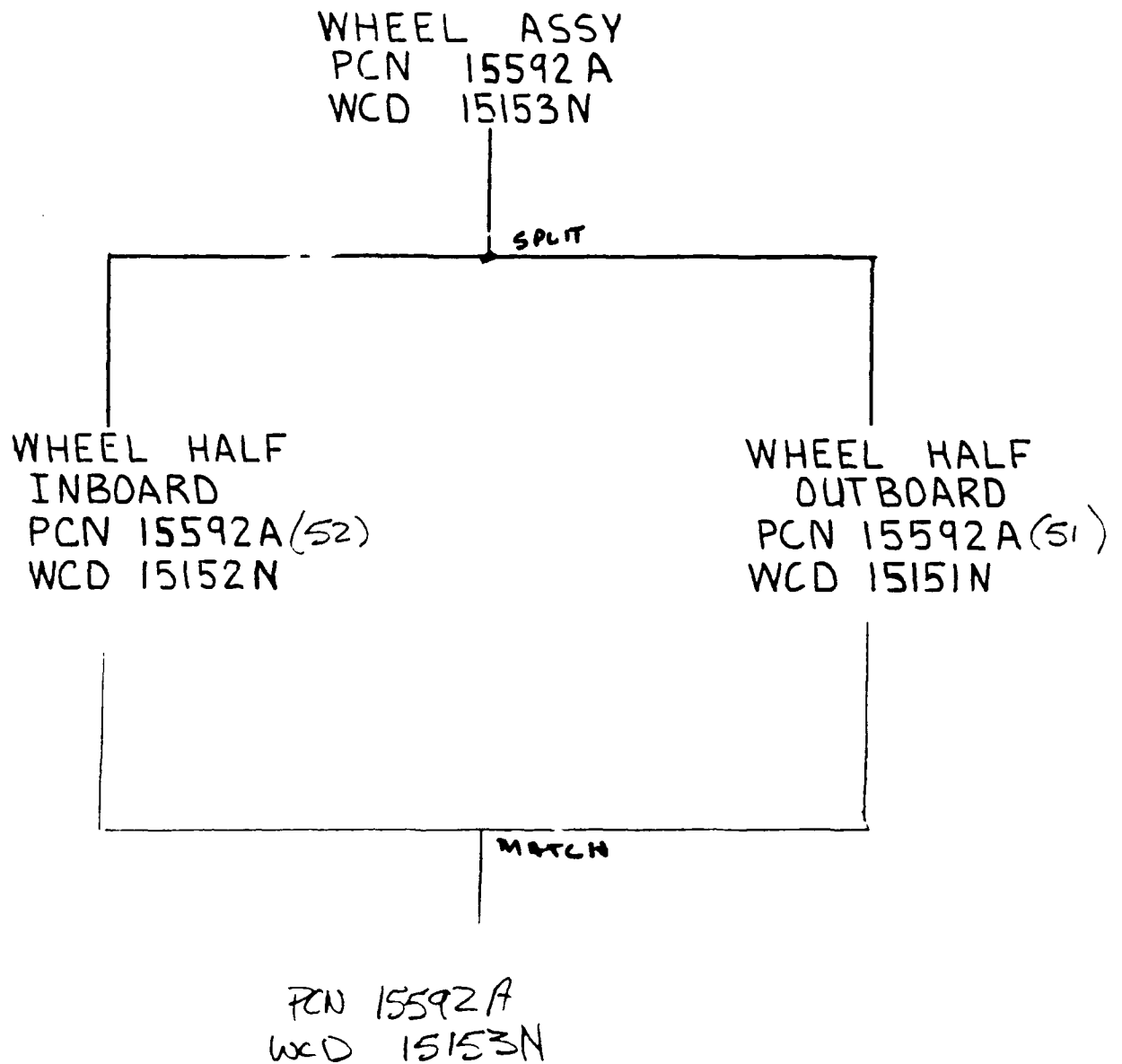
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LATEST DTD REVIEW 10 APR 89

4:37 PM

						FACTORED		
PROD NR	REL	OPER NR	TYP STD	SK	FAC	STAND HOURS	CCC FAC	STAND HOURS
15592A	MNPRK	XNPRK	X	4N	5	.51	1.00	51
								51
								51
	MNPRK	00010	E	YH	5	.05	1.00	5
		PM153	E	YH	5	.13	1.00	13
		OP151	E	3S	5	.33	1.00	33
		PS152	E	3S	5	.33	1.00	33
		PS153	N	3S	5	.42	1.00	42
		PS151	E	YH	5	.69	1.00	69
		PS152	E	YH	5	.69	1.00	69
								2.67
	MNPRK	WC001	E	KI	5	1.76	1.00	1.76
		WA001	E	KI	5	.70	1.00	70
		WA151	N	DI	5	.51	1.00	51
		WA152	N	DI	5	.51	1.00	51
		WA151	N	KI	5	.19	1.00	19
		WA152	N	KI	5	.19	1.00	19
								3.56
	MNPRK	NA151	E	DS	2	.21	.20	16
		NA152	E	DS	5	.31	.20	16
		NA153	E	DS	5	.31	.20	16
		XNPRK	X	DS	2	.40	1.00	40
								85
	MNPRK	KA151	E	JA	1	5.23	.20	1.05
		KA152	E	JA	1	5.31	.20	1.16
								2.21
								10.13

# KC-135 NOSE WHEEL



KC-135  
PCN 15592A  
WCD 15153N

IN INDUCT

S SPLIT WHEEL

WCD 15152N

WCD 15151N

5A DISASSEMBLE CHILLS,  
WEIGHTS, KEYS, ETC.

5A DISASSEMBLE CHILLS,  
WEIGHTS, KEYS, ET

6 HEAT TO 150°F -  
REMOVE BEARING CUP  
& STAMP WCD

6 HEAT TO 150°F -  
REMOVE BEARING CUP  
& STAMP WCD

7 CHEMICAL CLEAN

7 CHEMICAL CLEAN

7A REMOVE FROM  
CONVEYER

7A REMOVE FROM  
CONVEYER

9 BLAST CLEAN

9 BLAST CLEAN

9A LOAD ON  
CONVEYER

9A LOAD ON  
CONVEYER

13 MAGNESIUM CLEAN

13 MAGNESIUM CLEAN



↓  
15 & PENT INSPECT  
15A

15B UNLOAD FROM  
CONVEYER

16 EDDY CURRENT  
INSPECTION

18 BEAD BLAST

19 LOAD ON  
CONVEYER

19A MAGNESIUM CLEAN

30 REMOVE FROM CONVEYER

30A NICK & BURR

40 INSPECT

40A ROUTE FOR REPAIR

47 METAL SET

60 REAM HOLES

70 MACHINE MATING  
SURFACE

70A CHEM CLEAN

80 PENT INSPECT

90 BEAR BORE MACHINE

110 SEAT REPAIR  
↓

↓  
15 & PENT INSPECT  
15A

15B UNLOAD FROM  
CONVEYER

16 EDDY CURRENT  
INSPECTION

18 BEAD BLAST

19 NICK & BURR

40 INSPECT

40A ROUTE FOR REPAIR

47 METAL SET

60 REAM HOLES

70 MACHINE SURFACE

70A CHEM CLEAN

80 PENT INSPECT

100 BEAR BORE MACHINE

120 SEAT REPAIR

130 BOLT HOLE REPAIR

150 VALVE STEM REPAIR

170 DOW 7

180 LOAD  
↓



↓

130 BOLT HOLE REPAIR

140 GROOVE REPAIR

170 DOW 7

180 LOAD

180A CLEAN

180B PROCESS  
(IMPREGNATE)

180C CLEAN

180D CURE

180E CLEAN

190 INSTALL CUP

195 MACHINE CUP

200 INSTALL BUSHING

205 INSTALL CUP

210 MACHINE BUSHING

215 INSTALL BUSHING

220 INSTALL BUSHING

260 INSPECT

265 HEAT WHEEL

265A INSTALL RACE

↓

↓

180A CLEAN

180B PROCESS  
(IMPREGNATE)

180C CLEAN

180D CURE

180E CLEAN

185 INSTALL CUP

190 MACHINE CUP

195 INSTALL BUSHING

220 INSTALL BUSHING

260 INSPECT

265 HEAT WHEEL

265A INSTALL RACE

265B UNLOAD FROM LINE

270 LOAD ON  
PAINT LINE

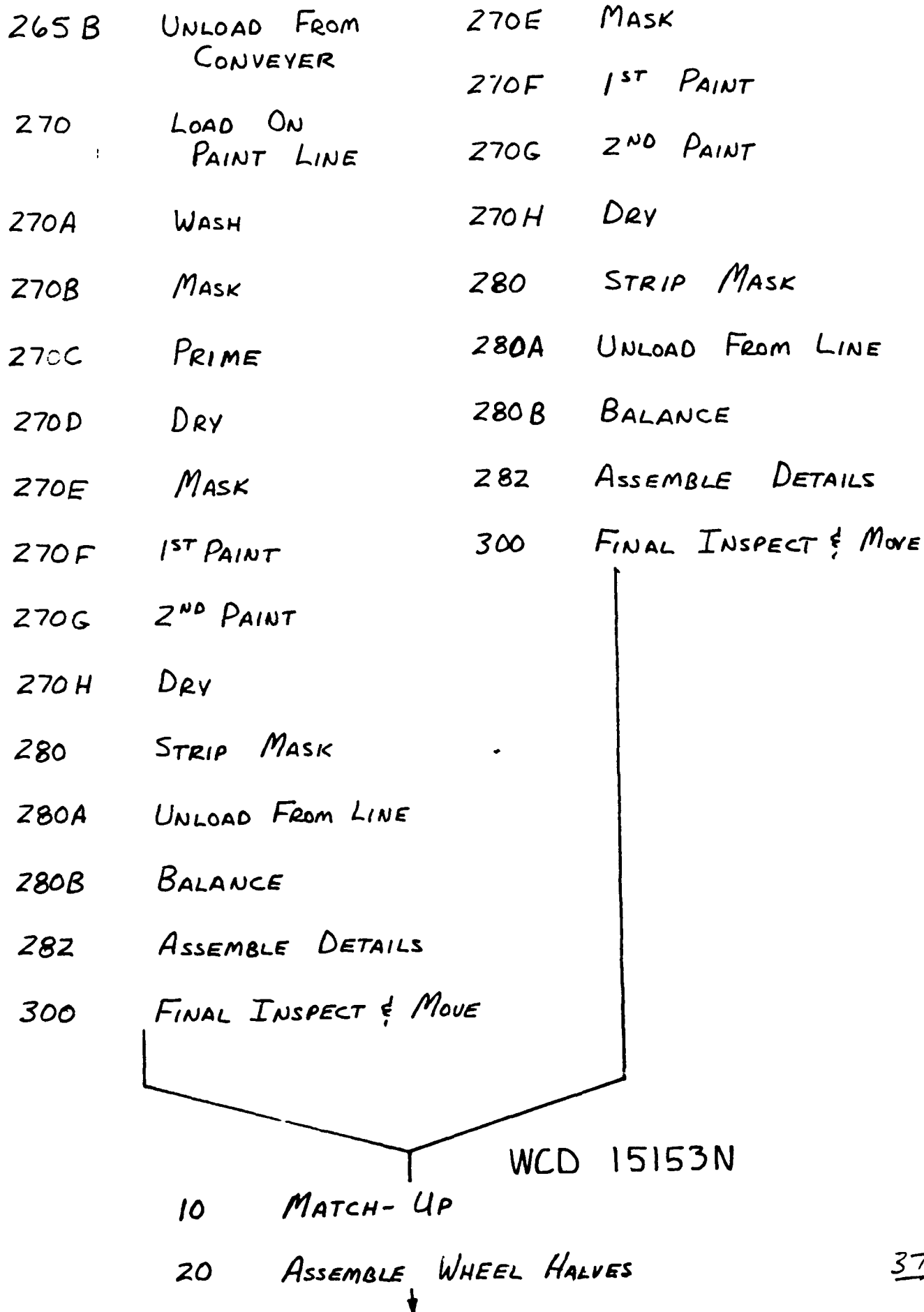
270A WASH

270B MASK

270C PRIME

270D DRY

↓



↓  
30 TOUCH UP PAINT

98 VERIFY WCD COMPLETENESS

99 FINAL VISUAL INSPECT

9999 SELL

## 15153N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88203

PAGE 1 OF 1 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC MNPOW	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA 4W-1-61 4W3-7-113	9 ITEM SERIAL NO
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10 MODEL-DESIGN-SERIES KC-135 NOSE	11 STOCK NUMBER	12 OPTIONAL 15143 A 15592 A
13 SERIAL NUMBER	14 NOUN WHEEL ASSY	

15. DISPATCH STATION	16. PERF RCC CP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
211A243M2		1630006896014 15143A			
211A243M3		1630004210319 15592A			
		***** UNIT COST: \$242.10 ***** GOVERNING DIRECTIVES: AFLOR 66-51 - MANDI 66-3			
		FPI IAW MIL-STD-6866 DOW IAW MIL-M-3171A *****MAGNESIUM*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND (CONTINUED)			

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/SN
DISPATCH FUNCTIONAL CODE	A C	15153N
	B D	

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## 15153N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88203

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL ASSY						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	211A243M 211A243M2 211A243M3							
13A	010	*MATCH-UP* *****ROUTED ITEMS***** *REQD* NEW REWORED NO SERVICEABLE 958 REWORK					001 MNP GP 002 07 003 MU02		
		W/H OUTBOARD / / 15151N W/H INBOARD / / 15152N							
		*C/P MOVE*							
13	020	ASSEMBLE *REQD*				*C/P MOVE		001 MNP GP 002 07 003 WA03	
13	030	FINAL PAINT & TOUCH-UP *REQD*				*C/P MOVE		001 MNP GP 002 09 003 TU04	
13	098	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQD*						001 MNP GP 002 09 003 TU04	
13	099	FINAL PRODUCT VISUAL INSPECTION *REQD*				*C/P MOVE		001 MNP GP 002 09 003 TU04	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		15153N			
		B		D					

## 15153N WORK CONTROL DOCUMENT (MEDS)

1 DATE 98203

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL ASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		15153N			
		B		D					

## 15151N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88210

PAGE 1 OF 1 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC MNPBW	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA 4W-1-61 4W3-7-113	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES KC-135 NOSE	11 STOCK NUMBER	12 OPTIONAL <b>15143 A</b> <b>15592 A</b>
13 SERIAL NUMBER	14 NOUN WHEEL HALF OUTBOARD	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
211A244-2		N.S.L. 15143A			
211A244-3		1630012427813 15592A			
		GOVERNING DIRECTIVES: AFLOR 66-51 MANOI 66-3 FPI IAW MIL-STD-6866 DOW IAW MIL-M-3171A			
		*****MAGNESIUM*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15151N
		B	D	

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15151N WORK CONTROL DOCUMENT (MEDS)				1 DATE 88210		2 PAGE 2 OF 2 PAGES	
2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED	
7 PART NUMBER		8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES		11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER		14 NOUN WHEEL HALF OUTBOARD					
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED			18 MECHANIC	19 "P"	20 "Q"
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.					
	001	211A244 211A244-1 211A244-2 211A244-3					
		DISASSEMBLE *C/P MOVE				001 MNPBW	
	*REQD*					002 02	
						003 WDO3	
		REMOVE CUP FROM WHEEL HALF *C/P MOVE				001 MNPBW	
	*REQD*					002 02	
						003 WDO3	
		CHEM CLEAN *C/P MOVE				001 MNPBW	
	*REQD*					002 03	
						003 AD02	
		BLAST CLEAN *C/P MOVE				001 MNPBW	
	*REQD*					002 03	
						003 BL01	
		MAGNESIUM CLEAN				001 MNPBW	
	*REQD*					002 03	
						003 MC04	
					*C/P MOVE	001 MNPNA	
	*REQD*				M	002 05	
						003 ZY05	
		BEAD, SEAT AND HUB AREAS				001 MNPNA	
	*REQD*	IAM T.O. PAGE 1 *C/P MOVE			M	002 05	
						003 EC04	
		GLASS BEAD BLAST ENTIRE WHEEL				001 MNPBW	
	*REQD*				*C/P MOVE	002 03	
						003 BL07	
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE			23 DOCUMENT/BN		
DISPATCH	FUNCTIONAL CODE	A			15151N		
		B					
		C					
		D					



2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
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10 MODEL DESIGN SERIES	11 STOCK NUMBER	12 OPTIONAL
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13 SERIAL NUMBER	14 NOUN
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WHEEL HALF OUTBOARD

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19	20
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NICK & BURR  
REMOVE TORQUE VALVE EXCEPT DRY  
TORQUE 500 INCH POUNDS  
EMBOSSED ON WHEEL HALVES

001 MNPBW  
002 04  
003 NB04

\*\*\* NOTE \*\*\*  
RE-IDENTIFY REMORKED WHEEL HALVES  
IAW T.O. 4W3-7-113  
\*C/P MOVE

E & I AND ROUTE  
TIE BOLT HOLE I.D. 0.453 MAX  
\*REQD\* TIE BOLT WALL THICKNESS 0.605 MIN  
(SEE IDENT. NOTE)

001 MNPBW  
002 04  
003 E102

OVERSIZE BRG BORE I.D. 4.361 MIN  
4.362 MAX  
\*C/P MOVE

69 047 METAL SET IAW T.O.

.05 \*C/P MOVE

001 MNPRA  
002 01  
003 BE01

69 060 REAM TIE BOLT HOLES TO REMOVE  
CORROSION .447 MIN .453 MAX ID IAW  
PAGE 6  
\*C/P MOVE

001 MNPRA  
002 01  
003 DR02

69 070 MACHINE MATING SURFACE & O RING  
SEALING SURFACE IAW PAGE 9  
\*C/P MOVE

001 MNPRA  
002 01  
003 LE05

05 (TYPE 1 METHOD C) TIE BOLT HOLES  
AFTER MACHINING FOR DRAGS IAW PAGE 7  
7 PARA (3)  
\*C/P MOVE

001 MNPRA  
002 05  
003 ZY05

\*\*\*\*\* NOTE \*\*\*\*\*  
IF LAST NDI OPERATION IS COMPLETED\*  
HERE, TAKE PRODUCTION COUNT.  
\*\*\*\*\*

69 100 BEARING BORE REPAIR (OUTBOARD)  
PAGE 8 & AF DWG 33B31152  
\*C/P MOVE

001 MNPRA  
002 01  
003 MV04

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15151N
		B	D	

## 15151N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88210

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF OUTBOARD						
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
✓ 69	120 .05	BEARING BORE SEAT REPAIR (OUTBOARD) IAW 63B31152 *C/P MOVE					001 MNPRA 002 01 003 MVD4		
✓ 69	130 .59	TIE BOLT HOLE REPAIR IAW PAGE 7 AND FIG 5 *C/P MOVE					001 MNPRA 002 01 003 DR02		
✓ 69	150 .05 <i>Added</i>	VALVE STEM HOLE REPAIR P/N 211A243M2 & P/N 211A243M3 ONLY IAW PAGE 9 FIG 6 *C/P MOVE					001 MNPRA 002 01 003 DR02		
✓ 69	160 .03 <i>Added</i>	VALVE STEM HOLE REPAIR P/N 211A243M ONLY IAW FIG 2 & 4 PAGE 9 PARA 5 * * * N O T E * * *					001 MNPRA 002 01 003 DR02		
		RE-IDENTIFY REWORKED WHEEL HALVES IAW T.O. 4WS-7-133 *C/P MOVE							
		TREAT (DOW 7) *C/P MOVE *REQD*					001 MNPBW 002 03 003 MCD4		
✓ 13	180 *REQD*	IMPREGNATE *C/P MOVE *REQD*					001 MNPBP 002 07 003 MIO4		
✓ 69	185 .63	INSTALL CUP INTO BEARING BORE BUSHING P/N 29520 P/N 63B31152-75					001 MNPRA 002 01 003 BE01		
✓ 69	190 .61	MACHINE O.D. OF BUSHING AND CUP ASSEMBLY P/N N.P.L. *C/P MOVE					001 MNPRA 002 01 003 LE09		
✓ 69	195 .80	INSTALL BUSHING AND CUP ASSEMBLY BEARING BORE P/N N.P.L. *C/P MOVE					001 MNPRA 002 01 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		15151N			
		B		D					

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA			9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL HALF OUTBOARD	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
✓ 69	220 <del>220</del> 73	INSTALL TIE BOLT HOLE BUSHING IAW PAGE 7 *C/P MOVE		001 MNPRA 002 01 003 BE01	
✓ 13	260 *REQD*	PRE-FINAL INSPECTION AND ASSEMBLE *C/P MOVE		001 MNP GP 002 07 003 PF05	
✓ 13	265 71	RACE INSTALLATION *C/P MOVE P/N29520		001 MNP GP 002 07 003 RI06	
✓ 13	270 *REQD*	PAINT *C/P MOVE		001 MNP GP 002 09 003 BS02	
✓ 13	280 *REQD*	BALANCE *C/P MOVE		001 MNP GP 002 07 003 WB01	
✓ 13	282 *REQD*	INSTALL SEALS & RETAINERS *C/P MOVE		001 MNP GP 002 07 003 WA03	
✓ 13	300 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNP GP 002 07 003 WA03	
✓ 13	310 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNP GP 002 07 003 WA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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PREVIOUS EDITION WILL BE USED

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2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF INBOARD						
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	211A245 211A245-1							
		DISASSEMBLE *C/P MOVE					001 MNP GW		
	*REQD*						002 02		
							003 WD03		
		REMOVE CUP FROM WHEEL HALF *C/P MOVE					001 MNP GW		
	*REQD*						002 02		
							003 WD03		
		CHEN CLEAN *C/P MOVE					001 MNP GW		
	*REQD*						002 03		
							003 AC02		
		BLAST CLEAN *C/P MOVE					001 MNP GW		
	*REQD*						002 03		
							003 BL01		
		MAGNESIUM CLEAN					001 MNP GW		
	*REQD*						002 03		
							003 MC04		
		*C/P MOVE				M	001 MNP NA		
	*REQD*						002 05		
							003 ZY05		
		BEAD, SEAT AND HUB AREAS IAW T.O. PAGE 1 *C/P MOVE				M	001 MNP NA		
	*REQD*						002 05		
							003 EC04		
		GLASS BEAD BLAST ENTIRE WHL *C/P MOVE					001 MNP GW		
	*REQD*						002 03		
							003 BL07		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		15152N			
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA			9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL HALF INBOARD	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		SECOND MAG CLEAN FOR NICK & BURR *C/P MOVE*		001 MNPBW 002 04 003 NB04	
		NICK & BURR REMOVE TORQUE VALUE EXCEPT DRY TORQUE 500 INCH POUNDS EMBROSSED WHEEL HALVES *C/P MOVE*			
		E & I TIE BOLT HOLE I.D. 0.453 MAX TIE BOLT WALL THICKNESS 0.605 MIN (SEE IDENT NOTE)		001 MNPBW 002 04 003 EI02	
		1ST OVERSIZE BEARING BORE I.D. 5.116 MIN TO 5.117 MAX 2ND OVERSIZE BEARING BORE I.D. 5.237 MIN 5.242 MAX. *C/P MOVE			
69	047 32	METAL SET IAW I.D. *C/P MOVE		001 MNPRA 002 01 003 BE01	
69	060 15	REAM TIE BOLT HOLES TO REMOVE CORROSION .447 MIN .453 MAX ID IAW PAGE 6 *C/P MOVE		001 MNPRA 002 01 003 BR02	
69	070 03	MACHINE MATING SURFACE & O RING SEALING SURFACE IAW PAGE 7 *C/P MOVE		001 MNPRA 002 01 003 LE05	
	03	(TYPE 1 METHOD C) TIE BOLT HOLES AFTER MACHINING FOR CRACKS IAW PAGE 7 PARA (3) *C/P MOVE	M	001 MNPRA 002 05 003 ZY05	
***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * (CONTINUED)					

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15152N
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER		8 TECH DATA		9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL HALF INBOARD	

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
		*****			
69	090 .31	BEARING BORE REPAIR (INBOARD) IAW PAGE 8 & AF DWG 63B31152 *C/P MOVE		001 MNPRA 002 01 003 MVD4	
69	110 .03	BEARING BORE SEAT REPAIR (INBOARD) IAW 63B31152 *C/P MOVE		001 MNPRA 002 01 003 MVD4	
69	130 .66	TIE BOLT HOLE REPAIR IAW PAGE 7 AND FIG 5 *C/P MOVE		001 MNPRA 002 01 003 DRD2	
69	140 SA dropped	BEARING BORE & LOCK RING GROOVE REPAIR (INBOARD) IAW FIG 5B & PAGE 10B PARA X-1 *C/P MOVE		001 MNPRA 002 01 003 LV02	
		TREAT (DOW 7) *C/P MOVE *REQD*		001 MNPBW 002 03 003 MCD4	
13	180 *REQD*	IMPREGNATE *C/P MOVE		001 MNPBP 002 07 003 MID4	
69	190	INSTALL CUP INTO BEARING BORE BUSHING *C/P MOVE P/N42620 P/N63B31152-79		001 MNPRA 002 01 003 BED1	
69	195 AS	MACHINE O.D. OF BUSHING AND CUP ASSEMBLY P/N N.P.L. *C/P MOVE		001 MNPRA 002 01 003 LED9	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.		

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL HALF INBOARD	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
69	200 A2	INSTALL BUSHING AND CUP ASSY INTO BEARING BORE *C/P MOVE P/N N.S.L.		001 MNPRA 002 01 003 BE01	
69	205 66 604	INSTALL CUP INTO BEARING BORE AND LOCK RING BUSHING *C/P MOVE P/N 42620 P/N7729019-01		001 MNPRA 002 01 003 BE01	
69	210 59 60P	MACHINE O.D. OF BUSHING AND CUP ASSEMBLY *C/P MOVE P/N N.P.L.		001 MNPRA 002 01 003 LEO9	
69	215 59 60P	INSTALL BUSHING AND CUP ASSY INTO BEARING BORE *C/P MOVE P/N N.S.L.		001 MNPRA 002 01 003 BE01	
69	220 33	INSTALL TIE BOLT HOLE BUSHING IAW PAGE 7 *C/P MOVE		001 MNPRA 002 01 003 BE01	
13	260 *REQD*	PRE-FINAL INSPECTION AND ASSEMBLE *C/P MOVE		001 MNPGP 002 07 003 PF05	
13	265 33	RADE INSTALLATION *C/P MOVE P/N 42620		001 MNPGP 002 07 003 RI06	
13	270 *REQD*	PAINT *C/P MOVE		001 MNPGP 002 09 003 BS02	
13	280 *REQD*	BALANCE *C/P MOVE		001 MNPGP 002 07 003 WB01	
13	282 *REQD*	INSTALL SEALS & RETAINERS *C/P MOVE		001 MNPGP 002 07 003 WA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	15152N
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2 JOB ORDER NO <b>5592A</b>	3 QUANTITY <b>1ea</b>	4 PRODUCTION SEC RCC <b>MNPGW</b>	5 DATE SCHED	6 DATE COMPLETED <b>6 JUL 88</b>
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7 PART NUMBER	8 TECH DATA <b>4b-1-51 4W3-7-113</b>	9 ITEM SERIAL NO <b>3505/3004</b>
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10 MODEL DESIGN SERIES <b>KC-135 NOSE</b>	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN <b>WHEEL ASSY</b>	

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 P	20 O
P/N		NSN C/N			
211A243M		1630005166758 37989A			
211A243M2		1630006896014 15143A			
211A243M3		1630004210319 15592A			
		***** UNIT COST: \$242.10 *****			
		GOVERNING DIRECTIVES: AFLCR 66-51			
		MANOI 66-3			
		FPI IAW MIL-STD-6866			
		DOW IAW MIL-M-3171A			
		*****MAGNESIUM*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		*REQD* (MANDATORY REQUIREMENT) IN (CONTINUED)			

21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	15153N
		B	D	

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCT: ON SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL DESIGN SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN WHEEL ASSY							
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 O	
		COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
13	020 *REQD*	ASSEMBLE *C/P MOVE FEB 22 1989							
13	030 *REQD*	FINAL PAINT & TOUCH-UP *C/P MOVE				23 FEB 1989			
13	098 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 9580				23 FEB 1989			
13	099 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE				23 FEB 1989			
		COORDINATION PLANNING: LARRY PRICE WK MEASURE: KERRY COOP SCHEDULING: SUE WARD							
		PRODUCTION: ROGER MURRAY							
		QUALITY: ED OVERDIEK							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/EN			
DISPATCH	FUNCTIONAL CODE	A		C		15153N			
		B		D					

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## WORK CONTROL DOCUMENT (MEDS) / WIP

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2 JOB ORDER NO 15592A/84A	3 QUANTITY 1 EA	4 PRODUCTION SEC RCC MNPGW	5 DATE SCHED 20 OCT 1988	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA 4W-1-61 4W3-7-113	9 ITEM SERIAL NO 3505
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10 MODEL DESIGN SERIES KC-135 NOSE	11 STOCK NUMBER	12 OPTIONAL
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13 SERIAL NUMBER E17022	14 NOUN WHEEL HALF OUTBOARD
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15 DISPATCH STATION P7N	16 PERM REC'D NO	17 WORK TO BE ACCOMPLISHED NSN C/N N.S.L. 37989A N.S.L. 37989A N.S.L. 15143A 1630012427813 15592A	18 MECHANIC	19	20
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GOVERNING DIRECTIVES: AFLCR 66-51  
MANOI 66-3  
FPI IAW MIL-STD-6866  
DOW IAW MIL-M-3171A

\*\*\*\*\*MAGNESIUM\*\*\*\*\*

ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.

\*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.

## WARNING

MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.

(CONTINUED)

21 FINAL DESTINATION DISPATCH	22 COORDINATION/INITIATING RCC SIGNATURE/DATE A Tom Wilson 16 Sep 88 MNPGW 16 SEP 1988 B [Signature] 17 Sep 88	23 DOCUMENT/SN 15151N
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2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO	
10. MODEL DESIGN SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN WHEEL HALF OUTBOARD						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. IP	20. OT	
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	211A244 211A244-1 211A244-2 211A244-3							
34D	005	DISASSEMBLE *C/P MOVE							
	*REQD*	03 OCT 1988							
34D	006	REMOVE CUP FROM WHEEL HALF *C/P MOVE							
	*REQD*	03 OCT 1988							
34C	007	CHEM CLEAN *C/P MOVE							
	*REQD*	03 OCT 1988							
34B	009	BLAST CLEAN *C/P MOVE							
	*REQD*	03 OCT 1988							
34C	012	MAGNESIUM CLEAN							
	*REQD*								
34C	015	FPI *C/P MOVE							
	*REQD*								
34	017	EDDY - CURRENT BEAD, SEAT AND HUB AREAS IAW T.O. PAGE 1 *C/P MOVE							
	*REQD*								
34B	019	GLASS BEAD BLAST ENTIRE WHEEL *C/P MOVE							
	*REQD*	OCT 07 1988							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A				C			
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						15151N			

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1 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED		
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO			
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL				
13 SERIAL NUMBER			14 NOUN WHEEL HALF OUTBOARD							
15 DISPATCH		16 PERF RCC/OP NO		17 WORK TO BE ACCOMPLISHED			18 JAN 1988		19 JAN 1988	
21				NICK AND BURR REMOVE TORQUE VALVE EXCEPT DRY TORQUE 500 INCH POUNDS EMBOSSED ON WHEEL HALVES ***NOTE*** RE-IDENTIFY REWORKED WHEEL HALVES IAW T.O. 4W3-7-113 *C/P MOVE			2 - JAN 1988		mc	
34E		040		E & I ANL ROUTE TIE BOLT HOLE I.D 0.453 MAX *REQD* TIE BOLT WALL THICKNESS 0.605 MIN (SEE IDENT. NOTE)			2 - JAN 1988		M	
				OVERSIZE BRG BORE I.D. 4.361 MIN 4.362 MAX *C/P MOVE						
69		047		METAL SET IAW T.O. *C/P MOVE						
69		060		REAM TIE BOLT HOLES TO REMOVE CORROSION .447 MIN .453 MAX ID IAW PAGE 6 *C/P MOVE						
69		070		MACHINE MATING SURFACE & O RING SEALING SURFACE IAW PAGE 9 *C/P MOVE					M	
34Z		080		FPI (TYPE 1 METHOD C) TIE BOLT HOLES AFTER MACHINING FOR CRACKS IAW PAGE 7 PARA (3) *C/P MOVE			M		K	
				*****NOTE***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT.* *****						
69		100		BEARING BORE REPAIR (OUTBOARD) IAW PAGE 8 & AF DWG 63B31152 *C/P MOVE						
21		FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN		
DISPATCH		FUNCTIONAL CODE		A				15151N		
				B						
				C						
				D						

2 JOB ORDER NO		3 QUANT		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES		11 STOCK NUMBER				12 OPTIONAL			
13 SERIAL NUMBER		14 NOUN WHEEL HALF OUTBOARD							
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED					18 MECHANIC	19 P	20 Q
69	120	BEARING BORE SEAT REPAIR (OUTBOARD) IAW 63B31152 *C/P MOVE							
69	130	TIE BOLT HOLE REPAIR IAW PAGE 7 AND FIG 5 *C/P MOVE							
69	150	VALVE STEM HOLE REPAIR P/N 211A243M2 & P/N 211A243M3 ONLY IAW PAGE 9 FIG 6 *C/P MOVE						M	
69	160	VALVE STEM HOLE REPAIR P/N 211A243M ONLY IAW FIG 2 & 4 PAGE 9 PARA 5 * * * N O T E * * *						M	
		RE-IDENTIFY REWORKED WHEEL HALVES IAW T.O. 4W3-7-133 *C/P MOVE							
34C	L/D *REQD*	TREAT (DOW 7) *C/P MOVE 13 JAN 1980							
13	180 *REQD*	IMPREGNATE *C/P MOVE							
	185	INSTALL CUP INTO BEARING BORE BUSHING P/N 29520 P/N63B31152-75							
69	190	MACHINE O.D. OF BUSHING AND CUP ASSEMBLY P/N N.P.L. *C/P MOVE							
69	195	INSTALL BUSHING AND CUP ASSY INTO BEARING BORE P/N N.P.L. *C/P MOVE							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE					23 DOCUMENT/SN		
DISPATCH	FUNCTIONAL CODE	A					C		
		B					D		
							15151N		

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1 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA			9 ITEM SERIAL NO			
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOON WHEEL HALF OUTBOARD						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 O	
69	220	INSTALL TIE BOLT HOLE BUSHING IAW PAGE 7 *C/P MOVE							
13	260	PRE-FINAL INSPECTION AND ASSEMBLE *C/P MOVE *REQD* 14 FEB 1989					M		
13	265	RACE INSTALLATION P/N29520 *C/P MOVE 14 FEB 1989					M	71057	
13	270	PAINT *REQD* *C/P MOVE 14 FEB 1989					M	71010	
13	280	BALANCE *REQD* *C/P MOVE FEB 15 1989					M	71019 71019	
13	282	INSTALL SEALS & RETAINERS *C/P MOVE *REQD* FEB 15 1989					M	71019 71019	
13	300	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETION & AGENCY *REQD* OF ALL PRECEDING OPERATIONS TO 958 FEB 22 1989					M	71019 71019	
13	310	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD* FEB 22 1989					M	71019 71019	
		COORDINATED BY: PLANNING/WK MEASURE: TOM WIXOM SCHEDULING: JIM COLBIN PRODUCTION: ROGER MURRAY QUALITY: ED OVERDIER							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						15151N			



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2 JOB ORDER NO 5592A/84A		3 QUANTITY 1 EA		4 PRODUCTION SEC/RCC MANPCW		5 DATE SCHED 02 OCT 1988		6 DATE COMPLETED					
7 PART NUMBER			8 TECH DATA 4W-1-61 4W3-7-113			9 ITEM SERIAL NO 3004							
10 MODEL DESIGN SERIES KC-135 NCSE			11 STOCK NUMBER			12 OPTIONAL							
13 SERIAL NUMBER E395			14 NOUN WHEEL HALF INBOARD										
15 DISPATCH STATION P/N 211A245 211A245-1 211A245-1		16 PERF RCC/OP NO		17 WORK TO BE ACCOMPLISHED NSN C/N N.S.L. 37989A 1630012427824 15143A 1630012427804 15592A GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 FPI IAW MIL-STD-6866 DOW IAW MIL-M-3171A *****MAGNESIUM***** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.C.) AND T.C. SUPPLEMENTS REFERENCED. THE APPLICABLE T.C.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQC* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.				18 MECHANIC		19 P		20 Q	
21 FINAL DESTINATION DISPATCH FUNCTIONAL CODE		22 COORDINATION/INITIATING RCC SIGNATURE/DATE Frank H. Bigby MANUEL / 21 July 88 21 July 88 Ray Tallet 22 July 88				23 DOCUMENT/BN 15152N							

## 15152N WORK CONTROL DOCUMENT (MEDS)

DATE 88221

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA			9 ITEM SERIAL NO			
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF INECARD						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 O	
	001	211A245 211A245-1							
34D	005	DISASSEMBLE *C/P MOVE 03 OCT 1988				71204	71204		
34C	007	CHEM CLEAN *C/P MOVE 03 OCT 1988				70025	70025		
34E	009	BLAST CLEAN *C/P MOVE 03 OCT 1988				70025	70025		
34C	012	MAGNESIUM CLEAN *C/P MOVE 06 OCT 1988				70025	70025		
34Z	015	FPI *C/P MOVE 06 OCT 1988				70025	70025		
34	017	ELLY - CURRENT HEAD, SEAT AND RUE AREAS *REQD* IAW T.O. PAGE 1 *C/P MOVE 06 OCT 1988				70025	70025		
34B	019	GLASS HEAD BLAST ENTIRE WEL *C/P MOVE OCT 07 1988				70025	70025		
34E	021	NICK AND FURR REMOVE TORQUE VALUE EXCEPT DRY TORQUE 500 INCH POUNDS EMBOSSED WHEEL HALVES 11 OCT 1988				71737	71737		
34	040	TIE BOLT HOLE I.D. 0.453 MAX TIE BOLT WALL THICKNESS 0.605 MIN (CONTINUED)				71737	71737		
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		15152N			
		B		D					

## 15152N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88221

PAGE 3 OF 3 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCT: ON SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL/DESIGN SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN WHEEL HALF INBOARD							
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20	
		(SEE IDENT NOTE) 1ST OVERSIZE BEARING FOR I.D. 5.116 MIN TO 5.117 MAX 2ND OVERSIZE BEARING FOR I.D. 5.237 MIN 5.242 MAX. *C/P MOVE							
59	247 6226	METAL SET IAW T.C. *C/P MOVE				70699		NOV 1988	
69	262	BEAM TIE BOLT HOLES TO REMOVE CORROSION .447 MIN .453 MAX ID IAW PAGE 6 *C/P MOVE							
69	270	MACHINE MATING SURFACE & C RING SEALING SURFACE IAW PAGE 9 *C/P MOVE					M		
342	280	FPI (TYPE 1 METHOD C) TIE BOLT HOLES AFTER MACHINING FOR CRACKS IAW PAGE 7 PARA 13 *C/P MOVE					K		
		***** N C T E ***** IF LAST ADI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****							
69	290	BEARING FOR REPAIR (INBOARD) IAW PAGE 8 & AF DWG 63B31152 *C/P MOVE				70699		NOV 1988	
69	110	BEARING FOR SEAT REPAIR (INBOARD) IAW 63B31152 *C/P MOVE							
69	132	TIE BOLT HOLE REPAIR IAW PAGE 7 AND FIG 5 *C/P MOVE				70699		NOV 1988	
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		15152N			
		B		D					

## 15152N WORK CONTROL DOCUMENT (MEDS)

DATE 88221

PAGE 4 OF 4 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF INFOARD						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
69	140	BEARING CORE & LOCK RING GROOVE REPAIR (INFOARD) IAW FIG 5B & PAGE 10E PARA X-1 *C/P MOVE					M		
34C	170	TREAT (DOW 7) *C/P MOVE *REQD*							
13	180	IMPREGNATE *C/P MOVE *REQD*							
69	195	MACHINE BEARING CORE FUSHING P/N63E31152-79							
69	200	INSTALL BEARING CORE FUSHING & CUP (INFOARD) *C/P MOVE P/N63E31152-79 P/N42620							
69	225	MACHINE BEARING CORE & LOCK RING FUSHING IAW PAGES 10 & 10E AND DWG 7729219							
69	210	MFG & INSTALL BEARING CORE & LOCK RING FUSHING AND CUP (INFOARD) IAW PAGES 10 & 10E AND AF DWG 7729219 *C/P MOVE P/N7729219-01 P/N42620					M		
69	222	INSTALL TIE BOLT HOLE FUSHING IAW PAGE 7 *C/P MOVE							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE							
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
		15152N							

## 15152N WORK CONTROL DOCUMENT (MEDS)

1 DATE PE201

PAGE 5 OF 5 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL FALL INFOARD						
15 DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20	
13	260 *REQD*	PRE-FINAL INSPECTION AND ASSEMBLY *C/P MOVE 14 FEB 1989					71057		
13	265	RACE INSTALLATION *C/P MOVE							
13	270 *REQD*	PAINT *C/P MOVE 14 FEB 1989				71010			
13	280 *REQD*	BALANCE *C/P MOVE FEB 15 1989				71019	71019		
13	282 *REQD*	INSTALL SEALS & RETAINERS *C/P MOVE FEB 15 1989				71019	71019		
13	300 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETION OF ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 FEB 22 1989					71019		
13	310 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE FEB 22 1989					71019		
		COORDINATION PLANNING: FRANK RIGBY WK MEASURE: FRANK RIGBY SCHEDULING: SUE WARD							
		PRODUCTION: ROGER MURRAY QUALITY: ED OVERDIEK							
21 FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		15152N			
		B		D					

OPER TECH S S W F P P H A K REV

T K W R A FA SUPPORT

CCC <

DESCRIPTION

BASE

PFD

STD

A

STEP D L

K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

DLY PCT C

WD001	S	E	HB	EA	5	J	58335	1.00	PERCENT ENGR 99.9	DISSY WHL KC135N	.69		.69		
0001			HB	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010							211A243M			1630005166758					
0020							211A243M2			1630006896014					
0030							211A243M3			1630004210319					
0005			HB	01	25			1.00		DISASSEMBLE WHEEL MED/NOBRK	.167	.042	.209		30
0010	E					RWB-DW-05		1.00	DIS MED WHL (TIE BOLT NO B/K		.15704		.156		
0120	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012		
0006			HB	01	25			1.00		REMOVE BEARING CUPS	.389	.097	.487	.3	70
0010	E					RWB-BC-01		2.00	REMOVE BEARING CUPS		.16346		.408		
0020	E					RWB-MH-02		.50	LOAD HOOK W/WHEELS F/CLENING		.10532		.065		
0030	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012		
9000			HB	01	25			.01		LABOR STD HISTORY	.000	.000	.000		0
0010										03DEC84 2 YEAR REVIEW/NO TIME CHANGE					
0020										06JUN85 CHANGED SKL CODE,NO TM CHNG					
0030										10JUL85 DN GRD TO N ST/ADD N&B TM (TM WAS .67)					
0900										D.PARKER TECHN MANEAA					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRDP NR

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15592A

KC135 N WHL 211A243M3

RCC MNPBW

4W3-7-113

81050

OPER TECH S S W F PF A/R REV

STEP D L K C DC ELEMENT FACT OCC <----- DESCRIPTION -----> BASE FFD STD A  
HOURS TIME HOURS DLY PCT C

WE151	E	N	DI	EA	5	J	88335	1.00	PERCENT ENGR 12.3	E&I WHL HLF O.B. KC135N	.51		.51	
0001			DI	01	15			.00		PART NUMBER/NSN	.000	.000	.000	0
0010									211A244	N.S.L.				
0020									211A244-1	N.S.L.				
0030									211A244-2	N.S.L.				
0040									211A244-3	1630012427813				
0019			DI	01	27			1.00		NICK & BURR WHEEL MED/HALF	.250	.068	.318	62
0010	E							1.00	NICK & BURR PTS-CONST F/PREP		.02312		.029	
0020	N							1.00	NICK & BURR WHEEL MED/HALF		.21687		.275	
0030	E							1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
0040			DI	01	15			1.00		E & I AND ROUTE WHEEL	.167	.025	.193	38
0010	N							1.00	E&I AND ROUTE WHEEL HALF		.14919		.171	
0020	E							1.00	RENV WHL HLF F/PAINT CONVOYOR		.00633		.009	
0030	E							1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000			DI	01	15			.01		LABOR STD HISTORY-MORE	.000	.000	.000	0
0010										TIME NEEDED TO INSP & N & B				
0020										3 JUNE 1983 OLD TIME WAS .50				
0030										REQ D. BALLINGHAM				
0040										03DEC84 2 YEAR REVIEW/NO TIME CHANGE				
0900										N MONROE/MANEAA				

TERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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MMNPGH

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

12/13/88

A-E046B-MM1-DY-M45 PAGE 0001

15592A KC135 N WHL 211A243M3

RCC MMNPGH

4W3-7-113

81050

OPER TECH S S W F RF A/R REV

STEP D L K C DC ELEMENT FACT OCC <----- DESCRIPTION -----> BASE PFD STD A  
HOURS TIME HOURS DLY PCT C

WE152	E	N	DI	EA	5	J	88335	1.00	PERCENT ENGR 12.3	E&I WHL HLF I.B. KC135N	.51		.51	
0001			DI	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0
									211A245	NSL				
									211A245-1	1630012427804				
0019			DI	01	27			1.00		NICK & BURR WHEEL MED/HALF	.250	.068	.318	62
									RLG-RS-NC	1.00 NICK & BURR PTS-CONST F/PREP	.02312		.029	
										1.00 NICK & BURR WHEEL MED/HALF	.21687		.275	
									RJP-PW-R1	1.00 REM RPL PAPRMK SIGN OFF DOC	.01001		.012	
0040			DI	01	15			1.00		E & I AND ROUTE WHEEL	.167	.025	.193	38
										1.00 E&I AND ROUTE WHEEL HALF	.14919		.171	
									RWB-OH-W2	1.00 REMV WHL HLF F/PAINT CONVDOR	.00633		.009	
									RJP-PW-R1	1.00 REM RPL PAPRMK SIGN OFF DOC	.01001		.011	
9000			DI	01	15			.01		LABOR STD HISTORY-MORE	.000	.000	.000	0
										TIME NEEDED TO INSP & N & B				
										3 JUNE 1983 OLD TIME WAS .50				
										REG D. BALLINGHAM				
										03DEC84 2 YEAR REVIEW/NO TIME CHANGE				
										N MCNRGE/MAHEAA				

TO INTERROGATE LABOR STANDARDS, INPUT

PRD NRCP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

14. 06/58

A-E046B-MM1-DY-M45 PAGE 0001

15592A KC135 N WHL 211A243H3

RCC MNP SW

4W3-7-113

81050

QPER TECH S S W F FF A/R REV

[illegible]

WM151	S	N	KI	EA	5	J	88335	1.00	PERCENT	ENGR	27.9	DOW 7 WHL HLF 0/B KC135N	.18	.18		
0001			KI	01	15			.00				PART NUMBER/NSN	.000	.000	.000	0
							0010		211A244			N.S.L.				
							0020		211A244-1			N.S.L.				
							0030		211A244-2			N.S.L.				
							0040		211A244-3			1630012427813				
0170			KI	01	27			1.00				DOW MAG. WHEEL MED	.147	.040	.187	.7 100
							0010 E		RW2-CT-03	1.00	CHEM TREAT A MED MAG PART	.03116		.039		
							0020 N		ZLG-CL-M1	.50	LOAD & UNLOAD CARRIER CLEAN	.21200		.134		
							0030 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.012		
9000			KI	01	27			.01				LABOR STD HISTORY	.000	.000	.000	0
							0010		03DEC84 2 YEAR REVIEW/NO TIME CHANGE							
							0020		18JUL85 MOVED N&B TO HB SKL (TM WAS 1.47							
							0900		D.PARKER TECHN MANEAA							

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRCP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS  
RCC MNPBW

12/13/88  
4W3-7-113

A-E046B-MM1-DY-M45 PAGE 0001  
81050

15592A KC135 N WHL 211A24CM3

OPER TECH S S W F RF A/R REV

STEP D L K C DC ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE  
HOURS

PFD  
TIME

STD  
HOURS

A  
DLY PCT C

WM152	S	N	KI	EA	5	J	88335	1.00	PERCENT ENGR 27.9	DOW 7 WHL HLF I/B KC135N	.18		.18		
0001			KI	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0	
0010							211A245		NSL						
0020							211A245-1		1630012427804						
0170			KI	01	27			1.00		DOW MAG. WHEEL MED	.147	.040	.187	.7	100
0010	E						RWB-CT-03	1.00	CHEM TREAT A MED MAG PART		.03116		.039		
0020	N						ZLG-CL-M1	.50	LOAD & UNLOAD CARRIER CLEAN		.21200		.134		
0030	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DGC		.01001		.012		
9000			KI	01	27			.01		LABOR STD HISTORY	.000	.000	.000	0	
0010									03DEC84 2 YEAR REVIEW/NO TIME CHANGE						
0020									18JUL85 MOVED N&B TO HB SKL (TM WAS 1.47						
0900									D.PARKER TECHN MANEAA						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

12/06/88

A-E046B-MM1-DY-M45 PAGE 0001

15592A

KC135 N WHL 211A243M3

RCC MNPNA

4W3-7-113

OPER TECH S S W F FF A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
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NA151	S	E	DB	EA 2	J 88335	.20 PERCENT ENGR 99.9	NDI WHL HLF O.B. KC135N	.81	.16	
0001			DB	01	15	.00	PART NUMBER/NSN	.000	.000	.000
0010						211A244	N.S.L.			
0020						211A244-1	N.S.L.			
0030						211A244-2	N.S.L.			
0040						211A244-3	1630012427813			
0080			DB	01	11	.46	ZYGLO WHEEL MED	1.591	.081	.812 .7 100
0010 E						ZLG-ND-Z2 12.00	ZYGLO INSP MED PART BLD 507	.13177		1.755
0020 E						RJP-PW-R1 1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011
9000			DB	01	13	.01	LABOR STANDARD HISTORY	.000	.000	.000
0010						7NOV85 ADDED STEP 0040	DEGREASE (OLD STD .65)			
0900							KERRY COOP MANEAA TECHN 73357			

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

12/06/88

A-E046B-MM1-DY-M45 PAGE 0001

15592A

KC135 N WHL 211A243M3

RCC MMNPNA

4W3-7-113

OPER TECH S S W F PF A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	STOR	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
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NA152	S	E	DB	EA 5	J 88335	.20	PERCENT ENGR 99.9	NDI WHL HLF I.B. KC135N	.81		.16	
0001			DB	01 00		.00		PART NUMBER/NSN	.000	.000	.000	0
							211A245	NSL				
							211A245-1	1630012427804				
0080			DB	01 11		.46		ZYGLO WHEEL MED	1.591	.081	.812	.7 100
							ZLG-ND-Z2 12.00	ZYGLO INSP MED PART BLD 507	.13177		1.755	
							RJP-PW-R1 1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
9000			DB	01 13		.01		LABOR STANDARD HISTORY	.000	.000	.000	0
							7NOV85 ADDED STEP 0040 DECREASE (OLD STD .65)					
							KERRY COOP MANEAA TECHN 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRCP NR

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# LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/01/89

A-E046B-MM1-DY-M45 PAGE 0001

15592A KC135 N WHL 211A243M3

RCC MNPNA

4W3-7-113

PER TECH S S W F PF A/R REV

T K #R A FA SUPPORT

OCC

<-----

DESCRIPTION

BASE

PFD

STD

A

STEP D L

K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

ILY PCT C

0015	S	X	DB	EA	2	J 88335	1.00	PERCENT ENGR 99.9	NDI WHL KC135N	.39		.39		
0015			DB	01	11		.13		NDI TIE BOLTS 1ST TIME	1.005	.014	.145	36	
0010	E					ZLG-ND-M6	11.00	MAGNAGLO INSP SMALL OBJECT		.09138		1.115		
0020			DB	01	11		.13		NDI DRIVE KEYS 1ST TIME	.822	.012	.119	30	
0010	E					ZLG-ND-M6	9.00	MAGNAGLO INSP SMALL OBJECT		.09138		.912		
2000			DB	01	00		.00		PART NUMBER/NSN	.000	.000	.000	0	
0010								WCD ROUTED PARTS REQUIRING FPI						
0020								211A244	MSL					
0030								211A244-1	MSL					
0040								211A244-2	MSL					
0050								211A244-3	1630012427813					
0060								211A245	MSL					
0070								211245-1	1630012427804					
2001			DB	01	11		1.00		FPI 1ST TIME	.263	.029	.293	.8	73
0030	E					ZLG-ND-Z2	2.00	ZYGLO INSP MED PART BLD 507		.13177		.292		
2003			DB	01	11		1.00		EDDY CURRENT WHEEL	.083	.009	.093	23	
0010	E					ZLG-ND-E3	1.00	SET UP MACHINE -EDDY CURRENT		.03866		.042		
0020	E					ZLG-ND-E1	3.00	EDDY CURRENT - SURFACE SCAN		.00078		.002		
0030	E					ZLG-ND-E0	1.00	PROCESS TIME - PROBE TRAVEL		.00033		.000		
0040	E					ZLG-ND-E4	1.00	S.U. PROBE HOLDER RAD. SCAN		.00392		.009		
0050	E					ZLG-ND-E5	1.00	MATERIAL HANDLING TEST AREA		.00371		.004		
0060	E					ZPL-PW-L1	1.00	ENTER INFO IN LOG BOOK		.01951		.021		
0070	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
			DB	01	13		.01		LABOR STANDARD HISTORY	.000	.000	.000	0	
0010								7NOV85 ADDED STEP 0040 DEGREASE (OLD STD .65)						
0900								KERRY COOP MANEAA TECHN 73357						

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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15592A KC135 N WHL 211A243M3

RCC MNPRA

4WJ-7-113

OPER TECH S S W F PF A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	FFD TIME	STD HOURS	A DLY PCT C
RA152	S	E	JA	EA 1	J	39327	.20 PERCENT ENGR 98.4	MACH INBD WHL HALF KC-135N	5.80		1.16	
0001			JA	01	15		.00	PART NUMBER/NSN	.000	.000	.000	0
				0010			211A245	N.S.L.				
				0020			211A245-1	1630012427804				
0047			JA	01	15		.05	METAL SET REPAIR	.303	.002	.017	0
				0010	E	REM-SU-G1	1.00 S/U FOR BENCH WORK GENERAL		.27525		.316	
				0020	E	GTE-EP-PC	1.00 SEAL SMALL PART WITH EPOXY		.01864		.021	
				0030	E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0060			JA	01	15		.46	REP TIE BOLT HOLE,RAD DRILL	2.121	.146	1.122	19
				0010	E	RDR-SU-R1	.25 S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 4 PARTS	.56378		.162	
				0020	E	RDR-BO-A1	1.00 O/S BOSS W/STEP RMR RAD DRL		.30463		.350	
				0030	E	RDR-BO-A2	11.00 O/S ADNL BOSS STP RMR RAD DR	11 ADNL TIE BOLT HOLES	.14687		1.857	
				0040	E	RBW-DB-A1	12.00 DEBUR HOLE/CUTOUT BOTH SIDES	DEBUR 12 TIE BOLT HOLES	.00423		.058	
				0050	E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0070			JA	01	15		.05	MACHINE MATING SURFACE	.605	.005	.035	1
				0010	E	RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE		.49962		.574	
				0020	E	RLA-HP-C3	1.00 CHUCK SYMET PART IN 4 JAW		.09095		.104	
				0030	E	KML-FF-NB	1.00 FACE FINISH 9 TO 10 ADD 1/8		.00506		.005	
				0040	E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0090			JA	01	15		1.00	BEARING BORE REP - JIG BORE	.886	.133	1.020	18
				0010	E	RML-SU-V3	.25 S/U VERT MIL BORE FXTR HOIST	PRORATE OVER 4 PARTS	1.03687		.298	
				0020	E	RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
				0030	E	RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD		.12699		.146	
				0040	E	RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087	
				0050	E	KMM-BA-KC	1.00 BORE HOLE 5.5 X 1.5 GROUP 1		.25649		.294	
				0060	E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0110			JA	01	15		1.00	BEARING BORE SEAT REP,LARGE	.829	.124	.954	16
				0010	E	RML-SU-V3	.25 S/U VERT MIL BORE FXTR HOIST	PRORATE OVER 4 PARTS	1.03687		.298	
				0020	E	RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP	JIG BORE	.15776		.181	
				0030	E	RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD		.12699		.146	
				0040	E	RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087	
				0050	E	KMM-BA-KA	1.00 BORE HOLE 5.5 X 1/2 GROUP 1		.19948		.229	
				0060	E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0130			JA	01	15		.46	REP TIE BOLT HOLE,RAD DRILL	2.311	.160	1.223	21
				0010	E	RDR-SU-R1	.25 S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 4 PARTS	.56378		.162	
				0020	E	RDR-BO-A1	1.00 O/S BOSS W/STEP RMR RAD DRL		.30463		.350	
				0030	E	RDR-BO-A2	11.00 O/S ADNL BOSS STP RMR RAD DR	11 ADNL TIE BOLT HOLES	.14687		1.857	
				0040	E	KAL-SM-31	12.00 SPOT-FACE OR COUNTERBORE	12 TIE BOLT HOLES	.02004		.276	
				0050	E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0140			JA	01	15		.46	BEARING BORE & LOCK RING REP	.508	.035	.269	5
				0010	N		1.00	SET UP PENSOTTI	.16700		.192	
				0020	E		1.00	4 .26 MACHINE BEARING BORE	.29333		.337	
				0030	E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC/		.01001		.011	
				0040	E	RPL-MH-P1	1.00 GET PALLET JACK & MOVE PARTS/		.03815		.043	
0190			JA	01	15		1.00	INST CUP INTO BUSHING	.077	.012	.089	2
				0010	E	REM-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
				0020	E	REM-BU-AA	1.00 INSTALL ONE STRAIGHT BUSHING		.02062		.023	
				0030	E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0195			JA	01	15		1.00	MACH BEARING BORE BUSHING	.236	.036	.272	5
				0010	E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
				0020	E	RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
				0030	E	KML-TA-JC	1.00 DIA 5.00-6.00 REM .033-.250		.09193		.105	
				0040	E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	

0200	JA 01	15	1.00	INST BEARING BORE BUSH & CUP	.077	.012	.089	2
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0205	JA 01	15	1.00	INST CUP INTO B B & L R BUSH	.077	.012	.089	2
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0210	JA 01	15	1.00	MACH BEARING BORE BUSHING	.236	.036	.272	5
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030 E		KML-TA-JC	1.00 DIA 5.00-6.00 REM .033-.250		.09193		.105	
0040 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0215	JA 01	15	1.00	INST BEARING BORE BUSH & CUP	.077	.012	.089	2
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0220	JA 01	15	.74	INST TIE BLT BUSH OTED	.314	.035	.268	5
0010 E		RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES		.18669		.214	
0020 E		RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E		RBW-BU-A3	11.00 INST ADNL STRAIGHT BUSHING ELEVEN BUSHING		.00886		.112	
0040 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
9000	JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010				29AUG84 ADD SUB OP 0080 & 0090 <OLD STD> 1.19				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRGP NR

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15592A KC135 N WHL 211A243M3

RCC MNPRA

4W3-7-113

OPER TECH S S W F PF A/R REV

T K #R A FA SUPPORT

DCC &lt;

DESCRIPTION

BASE

PFD

STD

A

STEP D L K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

DLY PCT C

RA151	S	E	JA	EA 1	J	68327	.20	PERCENT ENGR 99.9	MACH OUTBD WHL HALF KC-135N	5.27		1.05		
0001			JA	01	15		.00		PART NUMBER/NSN	.000	.000	.000		0
0010						211A244		N.S.L.						
0020						211A244-1		N.S.L.						
0030						211A244-2		N.S.L.						
0040						211A244-3		1630012427813						
0047			JA	01	15		.05	METAL SET REPAIR		.303	.002	.017		0
0010	E					REW-SU-S1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316		
0020	E					GTE-EP-PC	1.00	SEAL SMALL PART WITH EPOXY		.01864		.021		
0030	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0060			JA	01	15		.46	REP TIE BOLT HOLE,RAD DRILL		2.121	.146	1.122		21
0010	E					RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS		.56378		.162		
0020	E					RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350		
0030	E					RDR-BO-A2	11.00	O/S ADNL BOSS STP RMR RAD DR 11 ADNL TIE BOLT HOLES		.14687		1.857		
0040	E					REW-DB-A1	12.00	DEBUR HOLE/CUTOUT BOTH SIDES DEBUR 12 TIE BOLT HOLES		.00423		.058		
0050	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0070			JA	01	15		.05	MACHINE MATING SURFACE		.605	.005	.035		1
0010	E					RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574		
0020	E					RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E					KML-FF-NB	1.00	FACE FINISH 9 TO 10 ADD 1/8		.00506		.005		
0040	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0100			JA	01	15		1.00	BEARING BORE REP - JIG BORE		.886	.133	1.020		19
0010	E					RML-SU-V3	.25	S/U VERT MIL BORE FXTR HOISTPRORATE OVER 4 PARTS		1.03687		.298		
0020	E					RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181		
0030	E					RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E					RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E					KRM-BA-KC	1.00	BORE HOLE 5.5 X 1.5 GROUP 1		.25649		.294		
0060	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0120			JA	01	15		1.00	BEARING BORE SEAT REP,LARGE		.829	.124	.954		18
0010	E					RML-SU-V3	.25	S/U VERT MIL BORE FXTR HOIST PRORATE OVER 4 PARTS		1.03687		.298		
0020	E					RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP JIG BORE		.15776		.181		
0030	E					RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E					RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E					KRM-BA-KA	1.00	BORE HOLE 5.5 X 1/2 GROUP 1		.19948		.229		
0060	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0130			JA	01	15		.46	REP TIE BOLT HOLE,RAD DRILL		2.311	.160	1.223		23
0010	E					RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS		.56378		.162		
0020	E					RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350		
0030	E					RDR-BO-A2	11.00	O/S ADNL BOSS STP RMR RAD DR 11 ADNL TIE BOLT HOLES		.14687		1.857		
0040	E					KAL-SM-31	12.00	SPOT-FACE OR COUNTERBORE 12 TIE BOLT HOLES		.02004		.276		
0050	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0150			JA	01	15		.25	VALVE STEM HOLE REP RAD DR		.459	.017	.132		3
0010	E					RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS		.56378		.162		
0020	E					RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350		
0030	E					REW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004		
0040	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0160			JA	01	15		.10	VALVE STEM HOLE REP RAD DR		.469	.007	.054		1
0010	E					RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS		.56378		.162		
0020	E					RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350		
0030	E					STL-TH-A1	1.00	TAP HOLE TO 0.25 IN THRD DIA		.01427		.016		
0040	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0185			JA	01	15		1.00	INST CUP INTO BUSHING		.077	.012	.089		2
0010	E					REW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS		.18669		.053		



0020 E	REW-BU-A4	1.00	INST ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0190 JA 01 15		1.00	MACH BEARING BORE BUSHING	.236 .036	.272	5
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	.49962	.143	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006	.011	
0030 E	KML-TA-JC	1.00	DIA 5.00-6.00 REM .033-.250	.09193	.105	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0195 JA 01 15		1.00	INST BEARING BORE BUSH & CUP	.077 .012	.089	2
0010 E	REW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669	.053	
0020 E	REW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0220 JA 01 15		.74	INST TIE BLT BUSH CTBD	.314 .035	.268	5
0010 E	REW-BU-S1	1.00	SET UP TO REBUSH BOSSES	.18669	.214	
0020 E	REW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	REW-BU-A3	11.00	INST ADML STRAIGHT BUSHING ELEVEN BUSHING	.00886	.112	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
9000 JA 01 15		.01	LABOR STANDARD HISTORY	.000 .000	.000	0
0010			29AUS84 ADD SUB QP 0080 & 0090 <OLD STD> 1.19			

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRDP NR

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LABOR STANDARD OPERATIONAL RESOURCE STANDARD AND METHOD ANALYSIS  
RCC MNFSP

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4WS-7-113

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81050

15592A KC135 N WHL 211A243M3

OPER TECH S S W F FF A/R REV

T K #R A FA SUPPORT OCC <-----

STEP D L K C DC ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE  
HOURS

PFD  
TIME

STD  
HOURS

A  
DLY PCT C

00010	S	E	YH	EA	5	J	88335	1.00	PERCENT ENGR 99.9	ASSY WHL KC135N	.08		.08	
0001			YH	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0
0010									211A243M	1630005166758				
0020									211A243M2	1630006896014				
0030									211A243M3	1630004210319				
0020			YH	01	21			1.00		FINAL WHL ASSEMBLY MED/NOERK	.069	.014	.084	100
0010	E							4.00	INSTL UNOBSTRUCTED TIE BOLT		.00975		.047	
0020	E							3.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.036	
9000			YH	01	21			.01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010									06JUN84 ADD SUB OP 0001 UNLOAD LINE<OLD STD> 1.68					
0020									06SEP84 ADD STEPS 0012 & 0013 <OLD STD> 1.76					
0030									03DEC84 2 YEAR REVIEW/NO TIME CHANGE					
0031									3MAR86 CHANGED SKILL CODE FROM YG TO YH					
0032									NO TIME CHANGE					
0900									KERRY COOP MANEAA TECHN 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRQF NR

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15592A KC135 N WML 211A243M3

RCC MNPGB

4W3-7-113

81050

OPER TECH S S W F PF A/R REV

T K #R A FA SUPPORT

CCC <

DESCRIPTION

BASE

PFD

STD

A

STEP D L

K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

DLY PCT C

PP153	E	N	3S	EA	5	J	88335	1.00	PERCENT ENGR	37.9	TOUCH UP PAINT WML KC135N	.41		.41		
0001			3S	01	00			.00			PART NUMBER/NSN	.000	.000	.000		0
0010							211A243M				1630005166758					
0020							211A243M2				1630006896014					
0030							211A243M3				1630004210319					
0030			3S	01	25			1.00			PAINT TOUCH UP SM & MED	.063	.016	.080		19
0010	E						RWB-FT-02	1.00	FINAL & TUCH UP MED/SM L WML			.05395		.067		
0020	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.012		
0098			3S	01	25			1.00			FINAL ACCEPTANCE OF W.C.D.	.132	.033	.166		40
0010	N							1.00			FINAL	.08000		.100		
0020	E						GJP-FP-B5	1.00	FILL OUT FORM 424 & ATTACH			.05255		.065		
0099			3S	01	25			1.00			FINAL VISUAL INSPECTION	.137	.034	.171		41
0010	N							1.00			FINAL VISUAL INSPECTION	.12700		.158		
0020	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.012		
9000			3S	01	25			.01			LABOR STANDARD HISTORY	.000	.000	.000		0
0010											06JUN84 REMOVE UNLOADING PAINT LINE <OLD STD>	.57				
0020											06SEP84 ADD STEPS 0005 & 0025 <OLD STD>	.55				
0030											03DEC84 2 YEAR REVIEW/NO TIME CHANGE					
0900											N MONROE/MAHEAA					

TO INTERROGATE LABOR STANDARDS, INPUT

ALL PRD NROP NR

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PMNPGP15592APM153

LABOR STANDARD OPERA IN RESOURCE STANDARD AND METHOD ANALYSIS  
RCC MNPGP

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4WS-7-113

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81050

15592A KC135 N WHL 211A243M3  
OPER TECH S S W F PF A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
PM153	S	E	YH	EA 5	J 98335	1.00	PERCENT ENGR 84.5	MATCH UP WHL KC135N	.13		.13	
0001		YH	01	00		.00		PART NUMBER/NSN	.000	.000	.000	0
0010					211A243M			1630005166758				
0020					211A243M2			1630006896014				
0030					211A243M3			1630004210319				
0010		YH	01	21		1.00		WHEEL MATCH UP	.110	.023	.134	100
0010	E			MGT-EE-24		1.00	GET EASY AND PLACE EXACT		.00097		.001	
0020	E			RWB-UP-P7		1.00	UNPK PARTS-BK KEY-SNAP RING		.08237		.099	
0030	N					1.00		MATCH WHEEL HALFS 2 HALFS	.01700		.020	
0040	E			RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
9000		YH	01	21		.01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010							06JUN84 ADD SUB OP 0001 & UNLOAD LINE<OLD STD> 1.68					
0020							06SEP84 ADD STEPS 0012 & 0013 <OLD STD> 1.76					
0030							03DEC84 2 YEAR REVIEW/NO TIME CHANGE					
0031							3MAR86 CHANGED SKILL CODE FROM Y6 TO YH					
0032							NO TIME CHANGE					
0900							KERRY COOP MANEAA TECHN 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRDP NR

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2MNP6P15592APP151

## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

1. 2/88

A-E046B-MM1-DY-M45 PAGE 0001

RCC MNP6P

4W3-7-113

81050

15592A KC135 N WHL 211A243M3

OPER TECH S S W F PF A/R REV

SUB T K #R A FA SUPPORT OCC

STEP D L K C DC ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

EASE

PFD

STD

A

HOURS

TIME

HOURS

DLY PCT C

PP151	S	E	3S	EA	5	J	88335	1.00	PERCENT ENGR 99.9	PAINT WHL HLF O/B KC135N	.33		.33		
0001			3S	01	15			.00		PART NUMBER/NSN	.000	.000	.000	0	
0010							211A244		N.S.L.						
0020							211A244-1		N.S.L.						
0030							211A244-2		N.S.L.						
0040							211A244-3		1630012427813						
0270			3S	01	25			1.00	PAINT WHEEL		.267	.067	.334	4.0 100	
0010 E							GPL-PA-01	4.00	INST NONTHEADED PLSTC PLUG		.00093		.004		
0020 E							GIG-SF-M1	1.00	MASK & UNMASK MEDIUM PART		.01242		.015		
0030 E							RWB-QH-W1	1.00	HANG WHL HLF ON PAINT CONVYR		.02336		.029		
0040 E							RWB-SC-02	1.00	PNT WHL HALF-ZINC CHROMATE		.11574		.144		
0050 E							RWB-SC-P3	1.00	PNT WHL HALF (2ND COAT) POLY 2 COATS		.10214		.127		
0060 E							RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
9000			3S	01	25			.01	LABOR STANDARD HISTORY		.000	.000	.000	0	
0010									06JUN84 REMOVE UNLOADING PAINT LINE <OLD STD> .57						
0020									06SEP84 ADD STEPS 0005 & 0025 <OLD STD> .55						
0030									03DEC84 2 YEAR REVIEW/NO TIME CHANGE						
0900									N MONROE/MANEAA						

TO INTERROGATE LABOR STANDARDS, INPUT

: PRD NROP NR

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1234567890123456 ELSE PUT IN END

E

15592A KC135 N WHL 211A243M3

RCC MNPSP

4W3-7-113

81050

OPER TECH S S W F PF A/R REV

STEP D L K C DC ELEMENT FACT STORED DESCRIPTION SUPPLEMENTAL BASE HOURS PFD TIME STD HOURS A DLY PCT C

PP152	S	E	3S	EA	5	J	88335	1.00	PERCENT ENGR 99.9	PAINT WHL HLF I/B KC135N	.33		.33		
0001			3S	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010							211A245		NSL						
0020							211A245-1		1630012427804						
0270			3S	01	25			1.00	PAINT WHEEL		.267	.067	.334	4.0	100
0010	E						GFL-PA-01	4.00	INST NONTHREADED PLSTC PLLG		.00093		.004		
0020	E						GIG-SP-M1	1.00	MASK & UNMASK MEDIUM PART		.01242		.015		
0030	E						RWB-GH-W1	1.00	HANG WHL HLF ON PAINT CONVYR		.02336		.029		
0040	E						RWB-SC-02	1.00	PNT WHL HALF-ZINC CHROMATE		.11574		.144		
0050	E						RWB-SC-P3	1.00	PNT WHL HALF (2ND COAT) POLY 2 COATS		.10214		.127		
0060	E						RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.012		
9000			3S	01	25			.01	LABOR STANDARD HISTORY		.000	.000	.000		0
0010									06JUN84 REMOVE UNLOADING PAINT LINE <OLD STD> .57						
0020									06SEP84 ADD STEPS 0005 & 0025 <OLD STD> .55						
0030									03DEC84 2 YEAR REVIEW/NO TIME CHANGE						
0900									N MONROE/MANEA						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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15592A

KC135 N WHL 211A243M3

RCC MMNPGP

4W3-7-113

81050

OPER TECH S S W F PF A/R REV

STEP D L K C DC ELEMENT FACT STORED DESCRIPTION SUPPLEMENTAL BASE HOURS PFD TIME STD HOURS DLY PCT C

PS151	S	E	YH	EA	5	J	88335	1.00	PERCENT ENGR 99.9	PREINSP&ASSY WHL HLF O/B KC1	.69		.69		
0001			YH	01	15			.00		PART NUMBER/NSN	.000	.000	.000		0
0010									211A244	N.S.L.					
0020									211A244-1	N.S.L.					
0030									211A244-2	N.S.L.					
0040									211A244-3	1630012427913					
0180			YH	01	21			1.00		IMPRESNATE WHEEL HALF	.225	.047	.273	.7	39
0010	E								RWB-EC-03	1.00 IMPREGNATE MED SIZED WHEEL	.21563		.260		
0020	E								RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.012		
0260			YH	01	21			1.00		PREINSPECTION WHEEL HALF	.015	.003	.019		3
0010	E								RWB-JP-W2	1.00 PREP TO ASSY OR DISSY WHEEL	.00442		.005		
0020	E								KAL-GC-46	1.00 INSPECT VISUAL	.00115		.001		
0030	E								RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.012		
0265			YH	01	21			1.00		RACE INSTALLATION WHL/HALF	.178	.037	.216		31
0010	E								RWB-BC-03	1.00 INSTALL BEARING CUPS	.16838		.203		
0020	E								RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.012		
0280			YH	01	21			1.00		BALANCE WHEEL HALF	.111	.023	.134		19
0010	E								GPL-PD-01	4.00 REM NONTHEADED PLASTIC PLUG	.00339		.016		
0020	E								GMC-MT-D1	1.00 REMOVE MASKING TAPE	.00191		.002		
0030	E								RWB-DH-W2	1.00 REMV WHL HLF F/PAINT CONVMOR	.00833		.010		
0040	E								RWB-BB-01	1.00 BALANCE WHEEL HALF	.07734		.093		
0050	E								RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.012		
0282			YH	01	21			1.00		INSTALL SEALS & RETAINERS	.041	.009	.050		7
0010	E								RWB-AW-B1	1.00 INSTL BEARING/SNAP RING SECURD	.02459		.029		
0020	E								RWB-AW-C1	1.00 INSTL TIRE CHANGE DATA PLATE	.00692		.008		
0030	E								RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.012		
9000			YH	01	21			.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010										06JUN84 ADD SUB CP 0001 & UNLOAD LINE<OLD STD> 1.68					
0020										06SEP84 ADD STEPS 0012 & 0013 <OLD STD> 1.76					
0030										03DEC84 2 YEAR REVIEW/NO TIME CHANGE					
0031										3MAR86 CHANGED SKILL CODE FROM Y6 TO YH *					
0032										NO TIME CHANGE					
0900										KERRY COOP MANEAA TECHN 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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OPER TECH S S W F PF A/R REV

STEP D L K C DC ELEMENT FACT DESCRIPTION BASE PFD STD A  
HOURS TIME HOURS DLY PCT C

PS152	S	E	YH	EA	5	J	88335	1.00	PERCENT ENGR 99.9	PRE INSP&ASSY WHL HLF I/B KC	.69		.69		
0001			YH	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010							211A245		NSL						
0020							211A245-1		1630012427804						
0180			YH	01	21			1.00	IMPREGNATE WHEEL HALF		.225	.047	.273	.7	39
0010	E						RWB-EC-03	1.00	IMPREGNATE MED SIZED WHEEL		.21563		.260		
0020	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
0260			YH	01	21			1.00	PREINSPECTION WHEEL HALF		.015	.003	.019		3
0010	E						RWB-JP-W2	1.00	PREP TO ASSY OR DISSY WHEEL		.00442		.005		
0020	E						KAL-6C-46	1.00	INSPECT VISUAL		.00115		.001		
0030	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
0265			YH	01	21			1.00	RACE INSTALLATION WHL/HALF		.178	.037	.216		31
0010	E						RWB-BC-03	1.00	INSTALL BEARING CUPS		.16838		.203		
0020	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
0280			YH	01	21			1.00	BALANCE WHEEL HALF		.111	.023	.134		19
0010	E						GPL-PD-01	4.00	REM NONTHEADED PLASTIC PLUG		.00339		.016		
0020	E						GMC-MT-D1	1.00	REMOVE MASKING TAPE		.00191		.002		
0030	E						RWB-QH-W2	1.00	REMOV WHL HLF F/PAINT CONVDOR		.00833		.010		
0040	E						RWB-BB-01	1.00	BALANCE WHEEL HALF		.07734		.093		
0050	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
0282			YH	01	21			1.00	INSTALL SEALS & RETAINERS		.041	.009	.050		7
0010	E						RWB-AW-B1	1.00	INSTL BEARING/SNAP RING SECURD		.02459		.029		
0020	E						RWB-AW-C1	1.00	INSTL TIRE CHANGE DATA PLATE		.00692		.008		
0030	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
0000			YH	01	21			.01	LABOR STANDARD HISTORY		.000	.000	.000		0
0010									06JUN84 ADD SUB GP 0001 & UNLOAD LINE<OLD STD> 1.68						
0020									06SEP84 ADD STEPS 0012 & 0013 <OLD STD> 1.76						
0030									03DEC84 2 YEAR REVIEW/NO TIME CHANGE						
0031									3MAR86 CHANGED SKILL CODE FROM Y6 TO YH						
0032									NO TIME CHANGE						
0900									KERRY COOP MANEAA TECHN 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRDP NR

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TECH S S		W F FF A/R REV		JOB T K		NR A FA SUPPORT		OCC <----->		DESCRIPTION		BASE		PFD		STD		A	
STEP D L		K C DC ELEMENT		FACT		STORED		SUPPLEMENTAL		HOURS		TIME		HOURS		DLY PCT C			
40001	S	E	KI	EA	5	J	88335	1.00	PERCENT ENGR 92.3	CLEAN WHL I/B KC135N	1.75			1.75					
0001		KI	01	00				.00	PART NUMBER/NSN		.000	.000	.000						
0010							211A243M		1630005166758										
0020							211A243M2		1630006896014										
0030							211A243M3		1630004210319										
0007		KI	01	27				1.00	CHEM CLEAN WHEEL (MAG)		.424	.114	.538					31	
0010	E				ZLG-CL-M1			2.00	LOAD & UNLOAD CARRIER CLEAN 2EA HALVES		.21200		.538						
0009		KI	01	27				1.00	BLAST CLEAN WHEEL MED		.217	.059	.277					16	
0010	E				RPL-SB-M2			1.00	SANDBLAST MED PART WALK-IN B		.10100		.129						
0020	N				ZLG-CL-M1			.50	LOAD & UNLOAD CARRIER CLEAN		.21200		.134						
0030	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012						
0013		KI	01	27				1.00	CHEM CLEAN WHEEL (MAG)		.424	.114	.538					31	
0010	E				ZLG-CL-M1			2.00	LOAD & UNLOAD CARRIER CLEAN 2EA HALVES		.21200		.538						
0017		KI	01	27				1.00	BLAST CLEAN WHEEL		.316	.086	.403					23	
0010	E				RPL-SB-L2			1.00	SANDBLAST LARGE PART - HOISTGLASS BEAD		.31693		.402						
9000		KI	01	27				.01	LABOR STD HISTORY		.000	.000	.000					0	
0010									03DEC84 2 YEAR REVIEW/NO TIME CHANGE										
0020									10JUL85 MOVED N&B TO HB SKL (TM WAS 1.47										
0900									D.PARKER TECHN MANEAA										

INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRJP NR

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STL=STEEL  
AL=ALUMINUM  
MAG=MAGNESIUM  
TITA=TITANIUM  
SS=S STL  
SYN=SYNTHETIC  
LD=LEAD

## 852 MLG WHEEL ASSEMBLY

## BILL OF MATERIALS

69595A

\*\* = SHOP  
\* = MM

ROUTED	LOW LEVEL	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS	PER	OF	DATE	REASON	REVISION	TECH	ORD	PENDING	PENDING	PENDING	PENDING	PENDING	PENDING
ITEM	CODE						ASSY	MEAS											
10	13-1192-1		1630012286043	97153	WHEEL ASSEMBLY		11	EA											
11	300-254-1		1630011119667	25472	WHEEL HALF ASSY, INBOARD		11	EA											
12	N.P.L.		N.S.L.		WHEEL HALF SUBASSY, INBOARD		11												
13	N.P.L.		N.S.L.		BUSHING & CUP ASSY (PSEUDO)		11	AR											
14	63831152-33		1630009311012	98747	BUSHING & CUP ASSY (PSEUDO)		11	EA											
15	67324		3110005543196	60038	CUP, BEARING		11	EA											
16	N.P.L.		N.S.L.		BUSHING & CUP ASSEMBLY (PSEUDO)		11	AR											
17	191-338-1		5365001947078	22382	BUSHING, BRG & LCK RING (RPR)		11	EA											
18	67324		3110005543196	60038	CUP, BEARING		11	EA											
19	63832392-01		3120000139128	98747	BUSHING, TIE BOLT HOLE RPR/1ST OS/27 AR		11	EA											
20	66633001-535		N.S.L.	98747	BUSHING, TIE BOLT HOLE RPR		11	EA											
21	63832394-01		31200010197111E	98747	BUSHING, TIE BOLT HOLE RPR		11	EA											
22	153778		3120004026865LE	98747	BUSHING, TIE BOLT HOLE RPR		11	EA											
23	63832395-03		3120011002679	98747	BUSHING, DRIVE KEY INDEX HOLE RPR/9 AR		11	EA											
24	859726-01		N.S.L.	LOC MFG	BUSHING, DRIVE KEY INDEX HOLE RPR/9 AR		11	EA											
25	859726-03		3120012664214	98747	BUSHING, DRIVE KEY INDEX HOLE RPR/9 AR		11	EA											
26	63832393-01		3120008840354	98747	BUSHING, DRIVE KEY INDEX HOLE RPR/9 AR		11	EA											
27	153796		3120007334110LE	55284	BUSHING, KEY BOLT HOLE RPR		11	EA											
28	10-1061-1		N.S.L.	25472	WHEEL HALF, INBOARD		11												
29	67324		3110005543196	60038	CUP, BEARING		11	EA											
30	856-146		5310000121026	97153	RETAINER, FEL, INNER		11	EA											
31	ES0024-141		5330001804694	25472	FELT, PERFORMER		11	EA											
32	856-147		5330007576409	97153	RETAINER, FEL, OUTER		11	EA											
33	85-170		5365006145517	25472	LOCK RING		11	EA											
34	109535		5365001823259	55284	LOCK RING		11	EA											
35	80-586		5310008071467	96906	NUT, SELF-LOCKING		11	EA											
36	84960-10L		5310010531954	97153	WASHER, 30 DEGREES		11	EA											
37	191-279		5310006359800	88044	WASHER, FLAT		11	EA											
38	97-73		5305009592486	96906	BOLT, BALANCE AT		11	EA											
39	97-80		1630000556302	97153	WEIGHT, WHEEL BAL 1.00 OZ		11	EA											
40	97-107		1630001257170	97153	WEIGHT, WHEEL BAL 0.50 OZ		11	EA											
41	300-255-1		N.S.L.	56878	WEIGHT, WHEEL BAL 0.25 OZ		11	EA											
42	N.P.L.		1630011112990	25472	WHEEL HALF ASSY, OUTBOARD		11	EA											
43	N.P.L.		N.S.L.		WHEEL HALF SUBASSY OUTBOARD		11												
44	63831152-33		1630009311012	98747	BUSHING & CUP ASSY (PSEUDO)		11	AR											
45	67324		3110005543196	60038	BUSHING, BEARING BORE (RPR)		11	EA											
46	N.S.L.		N.S.L.		CUP, BEARING		11	EA											
47	191-339-1		1630007628199	22382	BUSHING & CUP ASSY (PSEUDO)		11	EA											
48	67324		3110005543196	60038	BUSHING, BRG & LCK RING (RPR)		11	EA											
49	63832394-01		3120001019711	98747	CUP, BEARING		11	EA											
50	66633001-555		N.S.L.		BUSHING, TIE BOLT HOLE RPR 1ST OS/27 AR		11	EA											
51	153778		3120004026865LE	98747	BUSHING, TIE BOLT HOLE RPR 2ND OS/27 AR		11	EA											

BLDG 505/507

652 MLG WHEEL ASSEMBLY

69595A

$$\begin{aligned} \text{H} &= \text{H} \\ \text{OH} &= \text{OH} \end{aligned}$$
[illegible]

BLDG 505/507

69595A

$$\begin{aligned} I_{HH} &= 0 \\ dOHS &= 0.0 \end{aligned}$$
[illegible]

PROD		OPER		TYP		STAND		OCC		FACTORED
NR	ACC	NR	STD	SK	FAC	HOURS	FAC	STAND	HOURS	
69595A	MNPRW	XNPRW	X	4N	5	.51	1.00		51	
										-----
										51
	MNPRW	DD10	E	YH	5	.54	1.00		54	
		PM10	E	YH	5	.13	1.00		13	
		PP102	E	SS	5	.33	1.00		33	
		PP105	E	SS	5	.33	1.00		33	
		PS102	E	YH	5	.42	1.00		42	
		PS105	E	YH	5	.42	1.00		42	
										-----
										2.47
	MNPRW	WDD01	N	KI	5	.93	1.00		93	
		WDD01	E	H3	5	1.52	1.00		1.52	
		WE102	N	DI	5	.62	1.00		62	
		WE105	N	DI	5	.62	1.00		62	
										-----
										3.69
	MNPRW	XNPRW	X	JB	1	.20	1.00		20	
										-----
										20
	MNPRW	NA102	E	DB	2	.02	1.00		2	
		NA105	E	DB	2	.02	1.00		2	
		XNPRW	X	DB	2	.39	1.00		39	
										-----
										43
	MNPRW	RA102	E	JA	1	1.34	1.00		1.34	
		RA105	E	JA	1	2.20	.65		1.43	
										-----
										2.77
	MNPRC	RC102	E	UP	3	1.99	1.00		1.99	
		RC105	E	UP	3	1.99	1.00		1.99	
										-----
										3.98
										-----
										14.05

# CONTROL NUMBER LIST

ITEM	CONTROL NO	ASSEMBLY	DESCRIPTION	STOCK NUMBER	PORT NUMBER	TECHORDER	DATE
DELE	69568A	C-130 MLG	PISTON	1620-00-954-8000	25 NOV 86	452-23-3	
BENT POLL	69569A	C-130 MLG	TORQUE STRUT ASSY	1620-00-605-0005	3880431	451-09-13	35
DELE	69572A	C-130 MLG	CYLINDER	1620-00-623-8912	25 NOV 86	451-37-3	
COOP POLL	69573A	C-130 MLG	TORQUE STRUT	1620-00-623-8913	388045-7	451-69-13	
BENT POLL	69577A	C-130 MLG	BRACE ASSY	1620-00-976-3391	371689-12	45A6-7-3	35
BENT POLL	69578A	C-130 MLG	STRUT ASSY	1620-01-143-1185	7926487-30	452-23-3	65
JENS PRIC	69589A	F-100 MLG	WHEEL	1630-00-667-4924	3-1080	443-7-1023	30
JENS PRIC	69591A	F-100 MLG	WHEEL	1630-00-696-3570	218A381	443-7-1293	30
RIGB PRIC	69595A	B-52	MAIN WHEEL	1630-00-212-8942	3-1192-1	481-4-133	30
DELE	69602A	F-106	GONE SWITCH	1440-00-942-1047AA	11 JULY 86	11L1-3-14-3	47
COVI SHEL	69603A	F-111	INERTIA REEL	1377-01-141-8911	0105157-77	11P9-11-3	07
MART SHEL	69621A	A-37	CONTROL BOX ASSY	1005-00-051-8786	DCX-144A320-9	11W1-15-12-2	04
BENT POLL	69626A	C-130 MLG	STRUT ASSY	1620-00-505-1104	3305591-3	452-23-3	65
BENT POLL	69651A	C-130 MLG	STRUT ASSY	1620-00-623-8911	370438-1	451-37-3	50
BENT POLL	69652A	C-130 MLG	STRUT ASSY	1620-00-111-1418	695001-9A	451-37-3	50
BENT POLL	69653A	C-130 MLG	COLLAR	1620-00-697-0191	352604	452-23-3	07
JENS RIGB	69654A	G-J F-16	BRAKE ASSY	1630-01-110-3642	5003063-6	481-2-1163	30
JENS POLL	69655A	G-J C-130	BALLSCREW	1620-01-065-4867	843012	1663-2-07-3	20
BENT COOP	69657A	KC-135 MLG	STRUT ASSY L/H	1620-01-030-9102	7531273-90	451-56-33	55
BENT COOP	69658A	KC-135 MLG	STRUT ASSY R/H	1620-01-030-9101	7531273-100	451-56-3	55
DELE	69697J	C-141 MLG	ORIFICE TUBE	1620-00-202-5315	2 JAN 85	451-73-3	
COOP	69707A	F-15 MLG	LOMER BRACE	1620-00-305-2009	680450771-1001	452-73-4	30
OLL	69775A	G C-141 MLG	ROOT PIN L	5315-00-500-6001LE	2430234-01	451-23-3	25
COOP TOLM	69777A	B-52 MLG	LOMER LINK	1620-00-217-4961	1-00604	451-20-4	25
JENS PRIC	69794A	J F-15 MLG	WHEEL	1630-01-141-4695	5000864-9	441-0-73	20
MONR TOLM	69803A	CH-3 MLG	STRUT ASSY	1620-01-000-0338	8341139-10	452-50-3	42
JENS RIGB	69807A	J F-15 MLG	A/B BRAKE ASSY	1630-01-010-2118	5000913-10	481-2-1123	23
MONR ANDE	69825A	C-5A MLG	UPPER BEARING	3120-00-251-7338LE	70869	452-67-3	31
DELE	69826A	F-16 MLG	DRAG STRUT	1620-01-101-1700	16 APR 86	45A6-32-3	
COOP TOLM	69833A	F-111 MLG	STRUT ASSY-SHOCK HM	1620-01-103-1950	1130100-503	451-07-3	50
DELE	69834A	F-16 MLG	DRAG STRUT	1620-01-070-9360	26 MAR 86	45A6-32-3	30
DELE	69853A	B-52	BOX END CROSSOVER	1005-00-890-9671	28 OCT 86	11F8-3-7-3	
COOP TOLM	69855A	G B-52 MLG	STEERING PLATE	1620-00-605-2760	5-60457-5	451-57-3	30
MART SHEL	69857A	A-10	EQUALIZER GAU-8	1005-01-003-0383	205F000	11W1-7-14-3	06
DELE	69865A	A-10	DRUM ASSY GAU-8	1005-01-003-1436	05-20-07	11W1-7-14-3	
DELE	69873A	J C-47 MLG	BRAKE	1630-00-959-2052	25 NOV 86	481-5-23	
DELE	69875A	E-101 MLG	UPPER TRUNNION ASSY	1620-01-005-3412	10 OCT 80	444-15-3-2	50
COOP TOLM	69887A	B-52 TIP	OUTER CYLINDER	1620-00-705-7201	5-96053-501	456-2-3-1	42
MONR ANDE	69898A	C-5A MLG	FORWARD DRAG LINK	1620-00-115-7433	4651437-107A	452-67-3	30
MONR ANDE	69899A	C-5A MLG	LOWER BEARING	3120-00-150-1799LE	4694453-101B	452-67-3	30
DELE	69915A	B-52	AMMO CAN	1005-00-21-3225	28 OCT 86	11W1-34-3-1	
DELE	69920A	E-16 MLG	STRUT ASSY	1620-01-070-2749	20 FEB 87	452-00-3	
CALD TOLM	71069A	F-111 MLG	LINK ASSY	1620-00-415-0200	12L9540-13	444-15-3	5
DELE	72827A	C-5A MLG	COMP. LINK	1620-00-007-0005	12 DECEMBER 86	451-04-3-3	
DELE	72836A	C-5A MLG	LOWER SIDE BRACE ARM	1620-00-115-7307	5-OCT-87	451-93-3	
DELE	72846A	G C-5A MLG	FLUID TRANS HOUSING	1620-00-110-7019	12 DECEMBER 86	451-93-3-1-103	12
MONR ANDE	72840A	C-0A MLG	UPPER TORQUE ARM F&C	1620-00-235-7031	0030432-101A	452-67-3-72	20
DE	72852A	C-5A MLG	TRUNNION PIN	1620-00-116-2099	4612400-101A	451-93-3	
DE	72877A	G C-5A MLG	STRUT ASSY	M 1620-00-432-5651	4651403-1036	452-67-3	40
MONR ANDE	72879A	C-5A MLG	OUTER CYLINDER	1620-00-446-3776	4611415-107A	451-93-3	

# B-52 MAIN WHEEL

WHEEL ASSY  
PCN 69595A  
WCD 16106N

WHEEL HALF  
INBOARD  
PCN 69595A  
WCD 16105N

WHEEL HALF  
OUTBOARD  
PCN 69595A  
WCD 16102N

WCD 16106N  
PCN 69595A  
88245

IN  
Induct into  
System

1A  
LOAD onto  
conveyor/workbench

1B  
Disassemble  
wheel halves

WCD 16102N  
88281

WCD 16105N  
88281

6  
Remove bearing race  
from wheel half

6  
Remove bearing race  
from wheel half

7  
Load onto chem  
clean line

7  
Load onto chem  
clean line

7A  
Cleaning Process

7A  
Cleaning Process



7B  
Unload from  
Cleaning Line

7B  
Unload from  
Cleaning Line

9  
Blast wheel  
half

9  
Blast wheel  
half

10  
Remove Bearings  
Bore bushing  
(If Required)

10  
Remove Drive  
Key bushings  
(If Required)

11  
Blast bearing  
Bore bushing area  
(If removed)

11  
Remove bearing  
bore bushing  
(If Req)

12  
LOAD onto  
Anodize strip  
line

12  
Blast bearing bore  
bushing area  
(If Removed)

12A  
Anodize strip

13  
LOAD onto Anodize  
Strip Line

15/15A  
Flourescent Particle  
Inspect

13A  
Anodize strip

15B  
Unload from  
FPI line

19  
Nick and Burr

40  
E and I  
Inspection

60  
machine wheel  
half mating  
surface

70  
Repair Valve  
stem hole  
(if Required)

90  
Tie bolt hole  
repair (if Req.)

95  
Pre Inspect Clean

15/15A  
FPI Inspect

15B  
Unload from  
FPI line

19  
Nick and Burr

40  
E and I Inspection

50  
Fusc Plug hole  
repair

60  
machine wheel  
half mating  
surface

70  
Repair tie bolt  
hole Boss face

80  
Repair Tie bolt hole

95A  
FPI. Inspection

85  
Pre Inspection  
Clean

150  
Bearing Bore Seat  
Repair (if Req)

85A  
FPI Inspect

160  
Bearing bore  
Repair (if Req)

87  
Bearing bore  
Seat Repair

180  
Bearing bore lock  
Ring Girder Repair  
(if Req)

90  
Bearing bore  
Repair

190  
Cracked wheel  
weight hole  
Repair (if Req)

100  
Machine Key  
bolt holes

210  
Cracked time counter  
hole repair (if Req)

110  
machine drive  
Key index holes

220  
Pre Inspect Clean

120  
Machine wheel ID  
Keyseat Area

220A  
FPI Inspection

225  
Clean wheel  
half

230  
Shot Peen

240  
A, B, C, D, E, F  
G, H, I, J, K  
Anodize process

250  
Install tie bolt  
bushing

260  
Install cup  
into bearing bore  
bushing

265  
machine OD  
of bushing &  
cup Assy

140  
Repair bearing  
bore lock ring  
Groove.

150  
Repair cracked  
wheel weight hole

155  
Repair cracked  
time counter hole

160  
Pre Inspect clean

160A  
FPI Inspection

170  
Clean wheel  
half

180  
Shot Peen  
wheel half

270  
Install bushing  
and cup Assy  
into bearing  
bore

280  
Install cup  
into bearing  
bore lock ring  
bushing

285  
Machine O.D.  
of bushing  
and cup Assy

290  
Install bushing  
and cup Assy  
into bearing  
bore.

330  
Install thread  
inserts

350  
Inspect, check paperwork  
and load on oven  
conveyor

190  
A, B, C, D, E, F  
G, H, I, J, K  
Anodize Process  
Type II Class I

200  
Install tie bolt  
bushing

204  
Install cup in  
bearing bore bushing

208  
Machine OD of  
bushing and cup Assy

210  
Install Bushing and  
cup Assy into bearing  
bore

212  
Install cup into  
bearing bore lock  
ring bushing

355  
Heat wheel  
halves in  
oven

355A  
Install bearing  
race in wheel  
half

355B  
move part to  
unloading conveyor

360  
LOAD Paint  
line

360A  
Trichloroethane  
wash wheel  
half

360B  
MASK AS Req.

360-C  
Prime wheel  
half

216  
machine OD of  
bushing & Cup Assy

220  
Install Bushing &  
Cup Assy into bearing  
bore

225  
machine key bolt  
hole bushing

230  
Install key bolt  
hole bushing

235  
machine drive key  
Index hole bushing

240  
Install Drive key  
index hole bushing

270  
move, check paperwork  
load onto bearing oven  
conveyor

360D  
Mandatory Dry  
time

360E  
1st Coat Paint

360F  
2nd Coat Paint

360G  
mandatory dry  
time

360H  
Strip Masking  
and plugs

360I  
unload from  
paint line

380 (390,400)  
Assemble Seals,  
Check paperwork  
Inspect.

275  
Heat wheel  
half

275A  
Install bearing  
race into wheel  
half

275B  
unload onto  
conveyor that feeds  
paint line

280  
Load paint line

280A  
trichloroethane  
wash

280B  
MASK & Plug

280C  
Prime wheel  
halves

280 D  
Mandatory Dry  
Time

280 E  
1st Coat Paint

280 F  
2nd Coat paint

280 G  
Minimum dry  
time

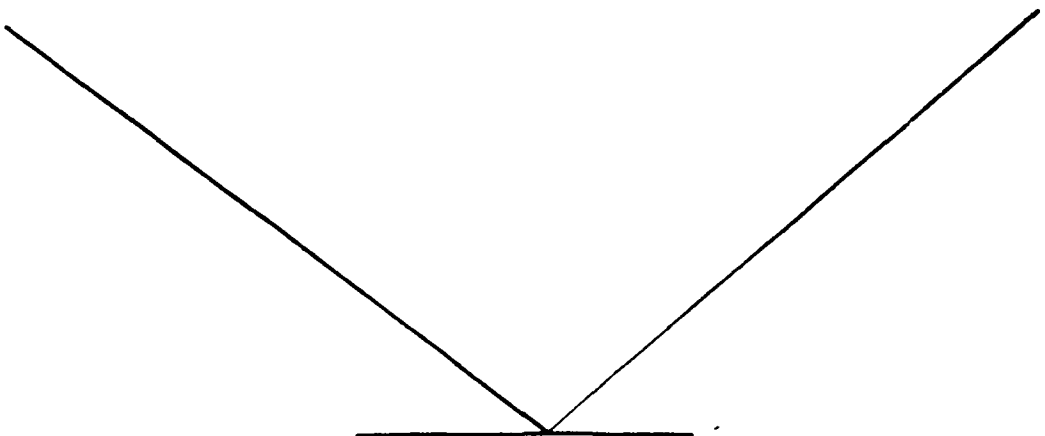
280 H  
Remove masking  
and Plugs

280 I  
LOAD onto wheel  
balance Conveyor

290  
Balance

295  
Assemble seals  
Check paper work  
Visual Inspection





WCD 16106N

<sup>10</sup>  
Match-up

<sup>15</sup>  
Assembly

<sup>20</sup>  
Touch up paint

<sup>997</sup>  
Final paperwork  
check

<sup>998</sup>  
Final Visual  
Inspection

<sup>9999</sup>  
SELL

## 16106N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88245

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2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO
		6W-1-61 101-7-1		

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
101-7-1		
13. SERIAL NUMBER	14. NOUN	
	APPLICABLE	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
17N		1630009009739 15139A 1630012286043 69595A2			
3-1192					
3-1192-1					
		*****UNIT COST \$2000.00**** GOVERNING DIRECTIVES: AFLOR 65-51 HARD1 65-2			
		*****ALUMINUM*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND ITS SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (O/F MOVED) FOR MOVED BETWEEN OPERATIONS/ALLOCATION STATIONS.			
		*****"W A R N I N G"***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		*REQD* (MANDATORY REQUIREMENTS) IN (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16106N
		B	D	

## 16-000 WORK CONTROL DOCUMENT (MEDS)

1 DATE 88245

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER		8 TECH DATA		9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL RENT	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		OCURR 18 IS EQUIVALENT TO DELTA STAMP.			
	001	3-1192 3-1192-1			
13	010 *REQD*	*MATCH-UP* ROUTED COMPONENTS NEW/SERVICEABLE REWORK NO REWORK		001 MATCH-UP 002 07 003 M012	
		WHEEL HALF SUBASSY (D.B.) 16102N WHEEL HALF SUBASSY (I.B.) 16105N			
13	015 *REQD*	ADJUSTABLE *O/P. MOVES*		001 ADJUST 002 07 003 W013	
13	020 *REQD*	FINAL TOUCH UP PAINT *O/P. MOVES*		001 FINISH 002 09 003 T004	
13	997 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 98		001 FINISH 002 09 003 T004	
13	998 *REQD*	FINAL PRODUCT VISUAL INSPECTION		001 FINISH 002 09 003 T004	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16-000
		B	D	

## 15102N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89201

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2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC REPAIR		5. DATE SCHED		6. DATE COMPLETED					
7. PART NUMBER				8. TECH DATA AD-1-01 AD-1-01				9. ITEM SERIAL NO.					
10. MODEL-DESIGN-SERIES 15102N			11. STOCK NUMBER			12. OPTIONAL  <b>15139A</b>							
13. SERIAL NUMBER			14. NOUN WHEEL HALF OUTBOARD										
15. DISPATCH STATION F/A		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED NBR 179 300-255 O.E. ASSY N.S.L. 15102N 300-255-1 DB ASSY 1630011112990 69595A			18. MECHANIC		19. "P"		20. "Q"		
				GOVERNING DIRECTIVES: AFLOR 66-51 MANOI 66-3									
				FPI IAW MIL-STD-6864									
				SHOT PEEN IAW MIL-S-13165 ANODIZE IAW MIL-A-8625									
				*****2014-T6 ALUMINUM*****									
				ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.									
				COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (O/P ROVE) BEFORE MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.									
				WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.									
				*EEDS (MANDATORY REQUIREMENTS) OF DELTA 15 IS EQUIVALENT TO DELTA (CONTINUED)									
21. FINAL DESTINATION DISPATCH FUNCTIONAL CODE			22. COORDINATION/INITIATING RCC SIGNATURE/DATE A C B D						23. DOCUMENT/SM				

## 101020 WORK CONTROL DOCUMENT (MEDS)

1 DATE 88281

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2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED		
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL				
13. SERIAL NUMBER			14. NOUN							
15. DISPATCH STATION		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED			18. MECHANIC		19. "P"	
		001		300-255 300-255-1						
34D		005		DISASSEMBLE					001 300-255 002 02 003 003	
		*REQD*								
34D		006		REMOVE LINK FROM WHEEL BUSH					001 300-255 002 02 003 003	
		*REQD*								
34C		007		OIL CLEAN					001 300-255 002 02 003 003	
		*REQD*								
34B		009		BLAST					001 300-255 002 02 003 003	
		*REQD*								
34		010		REMOVE BUSHING FROM WHEEL BUSH					001 300-255 002 01 003 003	
		01								
34B		011		BLAST BUSHING REMOVAL WHEEL					001 300-255 002 02 003 003	
		01								
34C		012		ANODIZE STRIP					001 300-255 002 02 003 003	
		*REQD*								
				WEIGHT HOLE CRACKED COUNTER HOLE CRACKED (CONTINUED)					001 300-255 002 02 003 003	
		*REQD*								

FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	101 020	
		B	D		

# WORK CONTROL DOCUMENT (MEDS)

DATE 88281

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2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN WHEEL HALF OUTBOARD	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34E	019 *REPAIR*	NICK & BURR *C/P MOVE*		001 MR: BW 002 04 003 NB04	
34E	040 *REPAIR*	E 3.1 AND RUDE BEARING BORE 7.980 MIN TO 7.992 MAX *C/P MOVE*		001 MR: BW 002 04 003 01 2	
	060	MACHINE RATING SUPPLY LAG 601 65H82291 *C/P MOVE*		001 MR: BW 002 01 003 LE05	
	070	VALVE STEM GLE REPAIR OUTBOARD IAW 65H82291 *C/P MOVE*		001 MR: BW 002 01 003 01 2	
	090	TIE BOLT HOLE REPAIR IAW 65H82291 65P22394, 65H82292 *C/P MOVE*		001 MR: BW 002 01 003 01 2	
		NDI NOTE	M	001 MR: BW 002 05 003 20 5	
	150	BEARING BORE SEAT REPAIR OUTBOARD IAW 65B31152 *C/P MOVE*		001 MR: BW 002 01 003 01 4	
	160	BEARING BORE REPAIR IAW 65B31152-30 *C/P MOVE*		001 MR: BW 002 01 003 01 4	
	180	BEARING BORE REPAIR IAW 65B31152-30 REPAIR (OUTBOARD) *C/P MOVE*		001 MR: BW 002 01 003 01 4	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	161000
		B	D	

## 16102N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88281

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
---------------	-------------	-------------------

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
------------------------	-----------------	-------------

13 SERIAL NUMBER	14 NOUN WHEEL HOLE REPAIR
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15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
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✓ 69 Y	190 .01	CRACKED WHEEL WEIGHT HOLE REPAIR *C/P MOVE*		001 2000 002 01 003 6812	
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✓ 69 1	210 .01	CRACKED TIME COUNTER HOLE REPAIR *C/P MOVE*		001 2000 002 01 003 6812	
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✓ 69 1	220 .01	CRACKED TIME COUNTER AND WEIGHT HOLE AFTER REPAIR *C/P MOVE* NDI NOTE	M	001 2000 002 05 003 2705	
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✓ 26	225 *REQD*	CLEAN WHEEL *C/P MOVE*		001 2000 002 02 003 6812	
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✓ 69	230 *REQD*	SHOT PEEN CW-26 SIZE 12 BALL BEARING 0.012 TO 0.014 A2 *C/P MOVE*		001 2000 002 01 003 6812	
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✓ 26	240 *REQD*	ANDSIZE TYPE 11 CLAYE & CLAYE *C/P MOVE*		001 2000 002 02 003 6812	
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✓ 69 1	250 .04	INSTALL TIE BOLT HOLE BEARING *C/P MOVE*		001 2000 002 01 003 6812	
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✓ 69 1	260 .04	INSTALL CUP INTO BEARING BORE BUSHING *C/P MOVE* P/N 67324 P/N 42001152-33		001 2000 002 01 003 6812	
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✓ 69 1	265 .04	MACHINE O.D. OF BUSHING & CUP ASSY P/N N.P.L.		001 2000 002 01 003 6812	
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✓ 69 1	270 .04	INS ALL BUSHING & CUP ASSY INTO BEARING BORE *C/P MOVE* P/N N.P.L.		001 2000 002 01 003 6812	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	16102N	
		B	D		

## 16102N WORK CONTROL DOCUMENT (MEDS)

1 DATE 28281

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2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN WHEEL HALL OUTBOARD						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69	200 .04	INSTALL CUP INTO BEARING BORE LIKE RING BUSHING P/N 67324 P/N 00					001 BR BR 002 01 003 BE01		
69	205 .01	MACHINE O.D. OF BUSHING AND CUP ASS P/N N.P.L.					001 BR BR 002 01 003 LI09		
69	290	INSTALL BUSHING & CUP ASSEMBLY INTO BEARING BORE *C/P COVER*					001 BR BR 002 01 003 BE01		
70	200 *RECU*	INSTALL HELICUILS *C/P COVER*					001 BR BR 002 01 003 BE01		
70	350 *RECU*	PRE-FINAL INSPECTION AND ADJUSTABLE *C/P COVER*					001 BR BR 002 07 003 PF05		
70	355 .47	RACE INSTALLATION *C/P COVER* P/N 67324					001 BR BR 002 07 003 RI06		
70	360 *RECU*	PAINT *C/P COVER*					001 BR BR 002 09 003 BE02		
70	370 *RECU*	BALANCE *C/P COVER*					001 BR BR 002 07 003 WE01		
70	380 *RECU*	INSTALL SEALS & RETAINERS *C/P COVER*					001 BR BR 002 07 003 WA03		
70	390 *RECU*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS PS					001 BR BR 002 07 003 WA03		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16102N
		B	D	



PREVIOUS EDITION WILL BE USED

## 16105N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88281

1  
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2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC MNFOW	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 4W-1-61 4W-7-1-41	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES BL 1 MAIN	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN WHEEL HALF INSIDE	15139A
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18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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PZ		NSN 15139A			
300-254-1 IB ASSY	I.B. ASSY N.S.L.	1630011119667	69595A		

		GOVERNING DIRECTIVES: AFLOK 66-51 MANUL 66-2			
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		FPT IAW MIL-STD-8836			
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		SHOT PEEN IAW MIL-S-13163			
		ANODIZE IAW MIL-A-8625			

		*****2014-T6 ALUMINUM*****			
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		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE			
--	--	--	--	--	--

		FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE			
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		APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
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		COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (EPA MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
--	--	--	--	--	--

		WARNING			
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		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS			
--	--	---	--	--	--

		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
--	--	--	--	--	--

		*REDD* (MANDATORY REMOVAL) IN COLUMN 16 IS EQUIVALENT TO DELTA (CONTINUED)			
--	--	--	--	--	--

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	16105N	
		B	D		

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1 DATE 88081

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2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN WHEEL HALF INBOARD	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		START			
	001	300-254 300-254-1			
34D	005 *REQD*	DISASSEMBLE *C/P MOVE*		001 MNR BW 002 02 003 WD03	
34D	006 *REQD*	REMOVE CUP FROM WHEEL HALF *C/P MOVE*		001 MNR BW 002 02 003 WD03	
34C	007 *REQD*	CHEM CLEAN *C/P MOVE*		001 MNR BW 002 03 003 AS02	
34B	009 *REQD*	BLAST *C/P MOVE*		001 MNR BW 002 03 003 BL01	
69	010 08	REMOVE DRIVE KEY UNDER BUSHING IF REQUIRED *C/P MOVE*		001 MNR BW 002 01 003 BK02	
69	011 01	REMOVE BEARING BORE BUSHING IF REQD *C/P MOVE*		001 MNR BW 002 01 003 BK01	
34B	012 04	BLAST BUSHING REMOVAL AREA *C/P MOVE*		001 MNR BW 002 03 003 BL01	
34C	013 *REQD*	APPROX. FINISH *C/P MOVE*		001 MNR BW 002 03 003 BK03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN
DISPATCH	FUNCTIONAL CODE	A	C	16105N
		B	D	

## 16105N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88281

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER		8 TECH DATA		9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL HALF INBOARD	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		WEIGHT HOLE CRACKED COUNTER HOLE CRACKED *REQD*		001 001 001 002 05 003 ZY05	
34E	019 *REQD*	NICK & BURR *C/P MOVE*		001 001 001 002 04 003 NB04	
34E	040 *REQD*	E & I AND ROUTE DRIVE KEY INDEX HOLE .628 MIN .630 MAX BEARING BORE 7.903 MIN 7.992 MAX *C/P MOVE*		001 001 001 002 04 003 EI02	
67 ✓	050 .01	FUSE PLUG HOLE REPAIR INBOARD IAW FIG 1A *C/P MOVE*		001 001 001 002 01 003 0002	
67 ✓	060 .01	MACHINE MATING SURFACE IAW DWG 65H32391 *C/P MOVE*		001 001 001 002 01 003 LE05	
67 ✓	070 .01	TIE BOLT HOLE BOSS FACE REPAIR IAW 65H32391 *C/P MOVE*		001 001 001 002 01 003 DR02	
67 ✓	080 .01	TIE BOLT HOLE REPAIR IAW 65H32391, 65B32394, 65B32392 *C/P MOVE*		001 001 001 002 01 003 DR02	
		NDI NOTE *C/P MOVE*	N	001 001 001 002 05 003 ZY05	
67 ✓	087 .01	BEARING BORE SEAT REPAIR (INBOARD) IAW 63B31152 *C/P MOVE*		001 001 001 002 01 003 MV04	
67 ✓	090 .01	BEARING BORE REPAIR (INBOARD) IAW FIG DWG 63B31152-33 *C/P MOVE*		001 001 001 002 01 003 LV02	

1. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	16105N
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2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	100	MACHINE KEY BOLT HOLES INBOARD IAW 68402291, 68102093 *C/P MOVE*		001 000000 002 01 003 DR02	
69	110	MACHINE DRIVE KEY INDEX HOLES INBOARD IAW FIG 4 *C/P MOVE*		001 000000 002 01 003 DR02	
69	120	MACHINE INBOARD WHEEL ID KEY SEAT AREA TO REMOVE CORROSION IAW DWG CONSOLE71 *C/P MOVE*		001 000000 002 01 003 LV02	
69	140	BEARING BOLT LOCK RING GROOVE (WHEEL INBOARD) *C/P MOVE*		001 000000 002 01 003 MV04	
69	150	CRACKED WHEEL MOUNT HOLE REPAIR (WHEEL INBOARD) *C/P MOVE*		001 000000 002 01 003 DR02	
69	160	CRACKED LINE COUNTER HOLE REPAIR (WHEEL INBOARD) *C/P MOVE*		001 000000 002 01 003 DR02	
69	170	CLEAN WHEEL *C/P MOVE*		001 000000 002 03 003 BE01	
69	180	SHOT PEEN WHEEL GLE TO INTENSITY OF 0.012 TO 0.014 A2 *C/P MOVE*		001 000000 002 01 003 SP01	
69	190	ANODIZE WHEEL *C/P MOVE*		001 000000 002 03 003 AD03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16105N
		B	D	

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF INBOARD						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
69 ✓	200	INSTALL TIE BOLT BUSHINGS 1ST REPAIR IAW 65B32391, 65B32393, 65H32391 *C/P MOVE*					001 MMRA 002 01 003 BE01		
69 ✓	204	INSTALL CUP INTO BEARING BORE BUSHING *C/P MOVE* P/N 67324 P/N 48B31152-23					001 MMRA 002 01 003 BE01		
69 ✓	208	MACHINE O.D. OF BUSHING AND CUP ASSY *C/P MOVE* P/N N.P.L.					001 MMRA 002 01 003 LE09		
69 ✓	210	INSTALL BUSHING & CUP ASSY INTO BEARING BORE *C/P MOVE* P/N N.P.L.					001 MMRA 002 01 003 BE01		
69 ✓	212	INSTALL CUP INTO BEARING BORE LOCK RING BUSHING *C/P MOVE* P/N 67324 P/N 001					001 MMRA 002 01 003 BE01		
69 ✓	216	MACHINE O.D. OF BUSHING & CUP ASSY *C/P MOVE* P/N N.P.L.					001 MMRA 002 01 003 LE09		
69 ✓	220	INSTALL BUSHING & CUP ASSY INTO BEARING BORE *C/P MOVE* P/N N.P.L.					001 MMRA 002 01 003 BE01		
69 ✓	225	MACHINE KEY BOLT HOLE BUSHINGS P/N 65B32393-01 (INBOARD) IAW DWG 65H32391 & 65B32393					001 MMRA 002 01 003 LE02		
69 ✓	230	INSTALL KEY BOLT HOLE BUSHINGS IAW 65H32391 & 65B32393 INBOARD PRESS FIT .001/.001 *C/P MOVE*					001 MMRA 002 01 003 LE01		
69 ✓	235	MACHINE DRIVE KEY INOX HOLE BUSHING P/N 65B32393-03 (INBOARD) FINISH TO .6267/.625 IAW FIG 3 & 4					001 MMRA 002 01 003 LE02		

1. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	16105N	
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## 16105h WORK CONTROL DOCUMENT (MEDS)

1 DATE 800801

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER		8 TECH DATA		9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN BUSHING INBOARD	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	240	INSTALL DRIVE KEY INDEX TUBE BUSHING JAN FIG 2 & 4 INBOARD .000 PRESS TO *C/P MOVE*		001 11 00 002 01 003 0501	
✓ 18	270	PRE-FINAL INSPECTION AND ASSEMBLY *C/P MOVE*		001 00 00 002 07 003 0505	
✓ 16	275	RADE INSTALLATION P/N 67024 *C/P MOVE*		001 00 00 002 07 003 R106	
✓ 11	280	PAINT *C/P MOVE*		001 00 00 002 09 003 0002	
✓ 10	290	BALANCE *C/P MOVE*		001 00 00 002 07 003 0501	
✓ 10	295	INSTALL SEALS & RETAINERS *C/P MOVE*		001 00 00 002 07 003 0003	
✓ 10	300	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY INBOARD OF ALL PRESSING OPERATIONS THIS 958		001 00 00 002 07 003 0003	
✓ 13	310	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE*		001 00 00 002 07 003 0003	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16105h
		B	D	

16106N WORK CONTROL DOCUMENT (MEDS)				1 DATE 28006		PAGE 1 OF 1 PAGES	
2 JOB ORDER NO 69575 A		3 QUANTITY 1 ea		4 PRODUCTION SEC RCC MNEGW		5 DATE SCHED	
6 DATE COMPLET_D		7 PART NUMBER		8 TECH DATA 4W-1-01		9 ITEM SERIAL NO 5805-5167	
10 MODEL DESIGN SERIES B02 MAIN		11 STOCK NUMBER 4W-1-01		12 FUNCTIONAL PAC			
13 SERIAL NUMBER		14 NOUN WHEEL ASSY					
15 DISPATCH STATION P/N 3-1192 3-1192-1		16 PERF RCC OP NO		17 WORK TO BE ACCOMPLISHED NSN 1630009009739 1630012286043 C/N 15139A 69595A		18 MECHANIC P Q	
				<p>*****UNIT COST \$2500.00*****</p> <p>GOVERNING DIRECTIVES: AFLOR 66-51 MANOI 66-3</p> <p>*****ALUMINUM*****</p> <p>ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.</p> <p>*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.</p> <p>*****'W A R N I N G'*****</p> <p>MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, &amp; CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.</p> <p>*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.</p>			
21 FINAL DESTINATION DISPATCH FUNCTIONAL CODE		22 COORDINATION/INITIATING RCC SIGNATURE DATE A B C D		23 DOCUMENT/SN 16106N			



## 16106N WORK CONTROL DOCUMENT (MEDS)

1 DATE

FEB 86

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES		11 STOCK NUMBER				12 OPTIONAL			
13 SERIAL NUMBER		14 NOUN WHEEL ASSY							
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
13	005	RECORD WHEEL S/N _____ P/N _____							
		****ROUTED COMPONENTS****  NEW/ REWORKED NO SERVICABLE 95E REWORK							
		WHL INBOARD 16105N WHL OUTBOARD 15102N							
13	010 *REQD*	ASSEMBLE *C/P MOVE				15102N 71152			
13	020 *REQD*	FINAL TOUCH UP PAINT *C/P MOVE				09 JUN 1986 71152			
13	997	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 95E				09 JUN 1986 71152			
13	998	FINAL PRODUCT VISUAL INSPECTION				09 JUN 1986 71152			
		COORDINATED BY: PLANNING: LARRY PRICE WF MEASURE: KERRY COOP SCHEDULING: SUE WARD							
		PRODUCTION: ROGER MURRAY							
		QUALITY: ED OVERDIEK							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		16106N			
		B		D					

2 JOB ORDER NO 395A/83A	3 QUANTITY 1EA	4 PRODUCTION SEC RCC MNPGR	5 DATE SCHED MAY 09 1980	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA 4W-1-61 4W1-7-1143		9 ITEM SERIAL NO 5805 (6)	

10 MODEL DESIGN SERIES B52 MAIN	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL HALF OUTBOARD	

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 P	20 "Q"
P/N		NSN C/N			
3-1192 ASSY		1630009009739 15139A			
10-1062 (O/B)		NSL 15139A			
3-1192-1 ASSY		1630012286043 69595A			
10-1062-1 (O/B)		1630011112990 69595A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		FPI IAW MIL-STD-6866			
		SHOT PEEN IAW MIL-S-13165			
		ANODIZE IAW MIL-A-8625			
		*****2014-T6 ALUMINUM*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO (CONTINUED)			

21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16102N
		B	D	

## 16102N WORK CONTROL DOCUMENT (MEDS)

DATE 8E063

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCT:ON SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF OUTBOARD						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
		PRECLUDE INJURIES.  *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
34D	001	DISASSEMBLE  *REQD* *C/P MOVE							
34C	002	CLEAN AS REQ'D  *REQD* *C/P MOVE							
69	005	REMOVE FAERING BORE BUSHING IF REQD *C/P MOVE*							
34C	007	BLAST PUSHING REMOVAL AREA *REQD* *C/P MOVE*							
34	010	YPI WEIGHT HOLE CRACKED YES/NO COUNTER HOLE CRACKED *REQD* *C/P MOVE							
34	030	NICK & BURR *REQD* *C/P MOVE							
34	040	E & I AND ROUTE BEARING BORE 7.988 MIN TO 7.992 MAX *REQD* *C/P MOVE							
69	060	MACHINE MATING SURFACE IAW DWG 65H32391 *C/P MOVE							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		16102N			
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## 16102N WORK CONTROL DOCUMENT (MEDS)

DATE 66063

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF OUTBOARD						
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
69	070	VALVE STEM HOLE REPAIR OUTBOARD IAW 65H32391 *C/P MOVE					M		
69	090	TIE BOLT HOLE REPAIR IAW 65H32391, 65B32394, 65B32392 *C/P MOVE							
34	095	FPI *C/P MOVE				M	K		
69	150	BEARING BORE SEAT REPAIR (OUTBOARD) IAW 65B31152 *C/P MOVE*							
69	160	BEARING BORE REPAIR (OUTBOARD) IAW 63B31152-33 *C/P MOVE							
69	180	BEARING BORE & LOCK RING GROOVE REPAIR (OUTBOARD) *C/P MOVE							
69	190	CRACKED WHEEL WEIGHT HOLE REPAIR *C/P MOVE							
69	210	CRACKED TIME COUNTER HOLE REPAIR *C/P MOVE							
69	220	FPI TIME COUNTER AND WEIGHT HOLE AFTER REPAIR *C/P MOVE				M	K		
26	225 *REQD*	CLEAN WHEEL *C/P MOVE							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		16102N			
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## 16102N WORK CONTROL DOCUMENT (MEDS)

1 DATE 86063

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES				11 STOCK NUMBER				12 OPTIONAL	
13 SERIAL NUMBER				14 NOUN WHEEL HALF OUTBOARD					
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
26	230	SHOT PEEN CW-28 SIZE TO INTENSITY OF 0.012 TO 0.014 A2 *REQD* *C/P MOVE				70344			
26	240	ANODIZE TYPE II CLASS I *C/P MOVE *REQD*				71097			
69	250	INSTALL TIE BOLT HOLE BUSHING AND MACHINE IAW 65H32391 65P32393 65H32591 PRESS FIT .000/.001 *C/P MOVE					M		
69	270	MFG & INSTALL BEARING BORE BUSHING AND CUP (OUTBOARD) IAW DWG 63B31152 PRESS FIT .007/.012 *C/P MOVE					M		
69	290	MFG & INSTALL BEARING BORE & LOCK RING BUSHING WITH CUP (OUTBOARD) PRESS FIT .007/.012 *C/P MOVE					M		
69	330	INSTALL HELICOILS *C/P MOVE *REQD*				70629			
13	350	OK TO ASSEMBLE *C/P MOVE *REQD*					M		
13	360	PAINT *C/P MOVE *REQD*							
13	370	BALANCE *C/P MOVE *REQD*							
13	380	INSTALL SEALS & RETAINERS *C/P MOVE *REQD*							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		16102N			
		B		D					

## 16102N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88063

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF OUTBOARD						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
13	390 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958				7115	71152		
13	400 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE JUN 9 1988					M		
		COORDINATED BY: PLANNING: LARRY PRICE WK MEASURE: DOUGLAS JENSEN SCHEDULING: SUE WARD							
		PRODUCTION: ROGER MURRAY							
		QUALITY: ED OVERDIEK							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		16102N			
		B		D					

## 15125A WORK CONTROL DOCUMENT (MEDS)

ALIAN PRO TIME TAKEN

2 JOB ORDER NO		3 QUANTITY		4. PRODUCTION SEE RCC		5 DATESCHED		6 DATE COMPLETED	
69595A/83A		1ea				11 APR. 1988			
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
				4W-1-61				5167	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
102 MAIN									
13 SERIAL NUMBER			14 NOUN						
			WHEEL HALF INNOA-D						
15 DISPATCH STATION		16 PERF RCC OP NO		17 WORK TO BE ACCOMPLISHED				18 MECHANIC	
I/N				NSN				P	
3-1192		ASSY		1632229079739				1513950	
12-1261		(I/P)		NSL				15139A	
3-1192-1		ASSY		1632229079739				69095A	
12-1261-1		(I/P)		1632311119667				69095A	
				GOVERNING DIRECTIVES: AFMCR 65-51					
				NANCI 66-3					
				PPI				IAW MIL-STD-883C	
				SHOT PEEN				IAW MIL-3-13165	
				ANODIZE				IAW MIL-A-8625	
				*****2214-16 ALUMINAL*****					
				ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS THEREON. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.					
				COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.					
				WARNING					
				MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO					
				(CONTINUED)					
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT'S					
DISPATCH		FUNCTIONAL CODE		A		C		16105N	
				B		D			

## 1512EN WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE 200

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN						
			WHEEL HALL INDOARD						
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20	
		PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
31D	221	DISASSEMBLE *C/P MOVE 11 APR 1988				71438	71438		
34C	222	CLEAN AS REQ'D *C/P MOVE APR 11 1988				70025	70025		
66	223	REMOVE BEARING BORE BUSHINGS IF REQUIRED *C/P MOVE 11 APR 1988				70339	70339		
66	225	REMOVE DRIVE KEY INDEX BUSHINGS IF REQUIRED *C/P MOVE*							
34	210	EPI *REQD* WEIGHT HOLE CRACKED COUNTER HOLE CRACKED *C/P MOVE YES NO				70298	70298		
34	232	NICK & BUFF *C/P MOVE 13 APR 1988				70298	70298		
34	242	E & I AND ROUTE *REQD* FIVE #1 INDEX HOLE .628 MIN .632 MAX BEARING BORE 7.985 MIN 7.992 MAX *C/P MOVE APR 12 1988				70298	70298		
66	252	FUSE PLUG HOLE REPAIR INDOARD IAW FIG 1A *C/P MOVE							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT'SN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						1512EN			



## 15165N WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE 1 OF 1

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SERIAL		5 DATE SHIPPED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN		15					
		WHEEL HALF INFOARD							
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 C	
59	260	MACHINE MATING SURFACE IAW DAG 65E32391 *C/P MOVE				58			
69	274	TIE BOLT HOLE LOSS FACE REPAIR IAW 65E32391 *C/P MOVE							
34	275	F.P.I. *C/P MOVE							
69	282	TIE BOLT HOLE REPAIR IAW 65E32391, 65E32394, 65E32392 *C/P MOVE							
34	285	FPI *C/P MOVE							
69	287	BEARING BOLE SEAT REPAIR (INFOARD) IAW 63E31182 *C/P MOVE							
69	294	BEARING BOLE REPAIR (INFOARD) IAW AF DAG 63E31182-33 *C/P MOVE							
69	122	MACHINE KEY BOLT HOLES INFOARD IAW 65E32391, 65E32393 *C/P MOVE							
69	112	MACHINE FIVE KEY INDEX HOLES INFOARD IAW FIC 4 *C/P MOVE							
69	122	MACHINE INFOARD WHEEL ID KEY SEAT AREA TO REMOVE CORROSION IAW DAG 65E32391 (CONTINUED)							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT'S N			
DISPATCH	FUNCTIONAL CODE	A		C		15165N			
		B		D					

## 15125A WORK CONTROL DOCUMENT (MEDS)

1 DATE

2007

PAGE 501 PAGE

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN			15			
			WHEEL HALL INICARD						
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20	
		*C/P MOVE							
69	142	BEARING HOLE & LOCK RING GROOVE REPAIR (INICARD) *C/P MOVE							
69	150	CRACKED WHEEL WEIGHT HOLE REPAIR HOLE .252 *C/P MOVE*							
69	155	CRACKED TIME COUNTER HOLE REPAIR HOLE #10 *C/P MOVE*							
69	152	FBI WHEEL WEIGHT AND TIME COUNTER HOLES AFTER REPAIR *C/P MOVE					K		
26	170	CLEAN WHEEL *C/P MOVE *RECD*							
26	182	SHOT PEEN CW-22 SIZE 10 INTENSITY OF 0.018 TO 0.014 A2 *RECD* *C/P MOVE							
26	192	ANCLIZE TYPE II CLASS I *C/P MOVE *RECD*							
69	212	INSTALL TIE BOLT BUSHINGS 1ST REPAIR IAW 65P32391, 65P32393, 65P32391 *C/P MOVE					M		
69	212	MIG & INSTALL BEARING HOPE BUSHING AND CUP INICARD IAW IAW 65P31152 PRESS FIT .0277/.212 CONTINUED							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		15125A			
		B		D					

## 16100A WORK CONTROL DOCUMENT (MEDS)

1 DATE

20 JUN 88

PAGE 1 OF 1 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN		WHEEL HALF INBOARD					
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 C	
		*C/P MOVE							
09	226	MFG & INSTALL BEARING BORE & LOCK RING BUSHING WITH CUP (INBOARD) PRESS FIT .227/.212 *C/P MOVE							
09	236	MACHINE & INSTALL KEY HOLE BUSHINGS IAW 60832391 & 60832392 INBOARD PRESS FIT .221/.221 *C/P MOVE							
09	242	MACHINE & INSTALL DRIVE KEY INDEX HOLE BUSHINGS IAW FIG 3 & 4 INBOARD .223 PRESS FIT *C/P MOVE				08 JUN 1988 70820	70820		
13	256	OK TO ASSEMBLE *C/P MOVE				08 JUN 1988	71057	71057	
17	264	PAINT *C/P MOVE				08 JUN 1988	70466		
13	280	BALANCE *C/P MOVE				JUN 9 1988	70126	70126	
13	298	INSTALL SEALS & RETAINERS *C/P MOVE				JUN 9 1988	70136	70136	
13	312	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY INBOARD OF ALL PRECEDING OPERATIONS THIS SEE				71152	71152		
13	312	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE				JUN 9 1988	71152	71152	
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT'S N			
DISPATCH	FUNCTIONAL CODE	A				16100A			
		B							

## PAGE 2 OF 4 PAGES

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SAME As PCN 69595A

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

RCC MNPW

441-7-1143 900-9739 81043

PER TECH S S W F PF A/R REV

SUB T K #R A FA SUPPORT OCC <----- DESCRIPTION -----> BASE PFD STD A

STEP D L K C DC ELEMENT FACT STORED SUPPLEMENTAL HOURS TIME HOURS DLY PCT C

0001	S	N	KI	EA 5	J 88298	1.00	PERCENT ENGR 69.4	CLEAN WHEEL B-52	.92		.92		
0001			KI	01	00	.00		PART NO. / N.S.N.	.000	.000	.000	0	
			0010			3-1192		1630009009739					
			0020			3-1192-1		1630012286043					
0007			KI	01	27	1.00		CHEM CLEAN WHEEL	.116	.031	.147	16	
			0010	N		ZLG-CL-M1	.50	LOAD & UNLOAD CARRIER CLEAN /	.21200		.134		
			0020	E		RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC/	.01001		.012		
0009			KI	01	27	1.00		BLAST CLEAN WHEEL LGE	.432	.117	.550	59	
			0010	E		RPL-SB-L2	1.00	SANDBLAST LARGE PART - HOIST	.31693		.402		
			0020	N		ZLG-CL-M1	.50	LOAD & UNLOAD CARRIER CLEAN	.21200		.134		
			0030	E		RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC	.01001		.012		
0012			KI	01	27	.10		BLAST CLEAN WHEEL LGE	.432	.012	.055	6	
			0010	E		RPL-SB-L2	1.00	SANDBLAST LARGE PART - HOIST	.31693		.402		
			0020	N		ZLG-CL-M1	.50	LOAD & UNLOAD CARRIER CLEAN	.21200		.134		
			0030	E		RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC	.01001		.012		
0013			KI	01	27	1.00		ANODIZE STRIP WHEEL ALUM	.136	.037	.173	.7	19
			0010	E		ZCD-ST-S1	1.00	ANODIZE STRIP	.12630		.160		
			0030	E		RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC	.01001		.012		
9000			KI	01	27	.01		LABOR STANDARD HISTORY	.000	.000	.000	0	
			0010					28DEC84 2 YEAR REVIEW/NO TIME CHANGE					
			0020					08MAY85 DWN GRD TO N STD (TM WAS .76)					
			0021					18SEPT86 2 YEAR REVIEW CHANGED OCC FACTOR STEP					
			0022					0010 SUBOP 0010 BOTH WHEELS HUNG ON 1 CARRIER					

0023

<OLD STL 2>

0900

KERRY COOP MANEL TECHN 73357

D INTERROGATE LABOR STANDARDS, INPUT

RCC PRO NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

5139A B52 M WHEEL 3-1192

RCC MNFGW

4W1-7-1143 900-9739 81043

ER TECH S S W F PF A/R REV

SUB	T K	#R A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A	
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
001	S	E	HB	EA 5	J 88300	1.00 PERCENT ENGR 99.9	DISSY. WHEEL B-52 M.	1.52		1.52	
0001			HB	01	00	.00	PART NO. / N.S.N.	.000	.000	.000	0
0010						3-1192	1630009009739				
0020						3-1192-1	1630012286043				
0005			HB	01	25	1.00	DISASSEMBLE	.776	.194	.971	64
0010	E					RWB-JP-W1 1.00 PREP TO DISASSEMBLE WHEEL		.01630		.020	
0030	E					RWB-HT-C3 1.00 HANDLING TOOLS PER END ITEM		.13837		.172	
0040	E					RWB-DW-T1 27.00 REM UNOBSR WHL TIE BOLT 27 EACH		.01056		.356	
50	E					RWB-DW-K4 9.00 DIS WHL (REM MULTI SCW B/K) 9 EACH		.02060		.231	
0060	E					RWB-DW-C2 2.00 REM DATA PLATE & STAMP WHL 2 EACH		.03067		.076	
0070	E					RWB-DW-B1 2.00 REM BEARING (SNAP RING SEC) 2 EACH		.01227		.030	
0090	E					RWB-DW-M1 1.00 DIS WHL (V/L-L & M WHEELS)		.04265		.053	
0100	E					RWB-DW-H1 1.00 REM HEAT SHIELD (SINGLE PC)		.00217		.002	
0120	E					RJP-PW-R1 1.00 REM RPL PAPWRK SIGN OFF DOC/		.01001		.012	
0130	E					RLG-RS-K1 1.00 /REMOVE TIE BOLT BUSHINGS		.01099		.013	
0006			HB	01	25	1.00	REMOVE BEARING CUPS	.442	.111	.553	.3 36
0010	E					RWB-BC-01 2.00 REMOVE BEARING CUPS		.16346		.408	
0020	E					RWB-MH-02 1.00 LOAD HOOK W/WHEELS F/CLEING		.10532		.131	
0030	E					RJP-PW-R1 1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
9000			HB	01	25	.01	LABOR STD HISTORY	.000	.000	.000	0
0010						26MAR85 2 YEAR REVIEW NO CHNG (OLD 1.01)					
0020						06JUN85 CHANGED SKL CODE NO TM CHNG					
0030						25JUN85 ADDED NICK&BURR TM (TM WAS 1.01)					

0031	20NOV85	LETED STEPS 0020,0115 SUPOP 0010 AND
0032		STEP 0030 SUBOP 0020 WORK NOT DONE IN HB SKILL
3		CODE <OLD STD 1.09>
0034		18SEPT86 2 YEAR REVIEW CHANGED NICK & BURR TIME
0035		<OLD STD .99>
0036		1DEC86 ADADDED STEP 0130 METHODS CHANGE (OLD 1.74)
0900		KERRY COOP MANEAA TECHN 73357

1 INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRDP NR

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15139A B52 M WHEEL 3-1192

RCC MNPBW

4W1-7-1143 900-9739 81043

ER TECH S S W F PF A/R REV

SUB	T K	#R A FA	SUPPORT	OCC	DESCRIPTION		BASE	PFD	STD	A
STEP D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
102	E	N	DI EA 5	J 88302	1.00 PERCENT ENGR 10.2	E&I WHEEL HALF O.B. B-52 M.	.61		.61	
0001		DI	01 00		.00	PART NO. / N.S.N.	.000	.000	.000	0
0010					300-255	N.S.L.				
0020					300-255-1	1630011112770				
0019		DI	01 27		1.00	NICK & BURR WHEEL LGE/HALF	.333	.090	.423	69
0010 E			RLG-RS-NC		1.00 NICK & BURR PTS-CONST F/PREP		.02312		.029	
0020 N					1.00	NICK & BURR WHEEL LGE/HALF	.29987		.380	
0030 E			RJP-PW-R1		1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
		DI	01 15		1.00	E & I AND ROUTE WHEEL	.167	.025	.193	31
0010 N					1.00	E&I AND ROUTE WHEEL HALF	.14919		.171	
0020 E			RWB-OH-W2		1.00 REMV WHL HLF F/PAINT CONVDOR		.00833		.009	
0030 E			RJP-PW-R1		1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000		DI	01 15		.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010						MOVE N&B TO E&I FROM CLEAN				
0020						26MAR85 2 YEAR REV.NO CHNG (OLD TM .83)				
0021						20NOV85 DELETED STEP 0040 WORK PERFORMED IN HB				
0022						SKILL CODE <OLD STD .83>				
0023						19SEPT86 DELETED STEP 0010 WORK PERFORMED BY KI				
0024						SKILL <OLD STD .40>				
0900						KERRY COOP MANEL TECHN 73357				

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

5139A B52 M WHEEL 3-1192

RCC MNPBW

4W1-7-1143 900-9739 81043

ER TECH S S W F PF A/R REV

SUB	T K	#R A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PF	STD	A	
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
105	E	N	DI	EA 5	J 88301	1.00 PERCENT ENGR 10.2	E & I WHEEL HALF INBD.B-S2M.	.61		.61	
0001		DI	01	00		.00	PART NUMBER / N.S.N.	.000	.000	.000	0
0010						300-254	N.S.L.				
0020						300-254-1	1630011119667				
0019		DI	01	27		1.00	NICK & BURR WHEEL LGE/HALF	.333	.090	.423	69
0010	E			RLG-RS-NC		1.00	NICK & BURR PTS-CONST F/PREP	.02312		.029	
0020	N					1.00	NICK & BURR WHEEL LGE/HALF	.29987		.380	
0030	E			RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.012	
		DI	01	15		1.00	E & I AND ROUTE WHEEL	.167	.025	.193	31
0010	N					1.00	E&I AND ROUTE WHEEL HALF	.14919		.171	
0020	E			RWB-OH-W2		1.00	REMY WHL HLF F/PAINT CONYOR	.00833		.009	
0030	E			RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
9000		DI	01	15		.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010							MOVE N&B TO E&I FROM CLEAN				
0020							26MAR85 2 YEAR REV.NO CHNG (OLD TM .83)				
0021							20NOV85 DELETED STEP 0040 WORK PERFORMED IN HB				
0022							SKILL CODE (OLD STD .83)				
0023							19SEPT86 DELETED STEP 0010 WORK PERFORMED BY KI				
0024							SKILL (OLD STD .40)				
0900							KERRY COOP MANEL TECHN 73357				

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

5139A B52 M WML 3-1192

RCC MNPNA

4W1-7-1143

ER TECH S S W F PF A/R REV

SUB	T K	HR A FA SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A	
STEP D L	K C	DC ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C

102	S	E DB EA 2	J 88302	1.00 PERCENT ENGR 99.9	NDI WHEEL HALF O.B. B-52M.	.02		.02	
0001		DB 01 00		.00	PART NO. / N.S.N.	.000	.000	.000	0
0010				300-255	N.S.L.				
0020				300-255-1	1630011112990				
0095		DB 01 11		.05	FPI 16102N	.181	.001	.010	50
0010 E		ZLG-ND-23	1.00	ZYGLO INSP LARGE PART BLD507,		.17130		.190	
0020 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC,		.01001		.011	
0220		DB 01 11		.05	FPI COUNTER HOLE 16102N	.181	.001	.010	50
010 E		ZLG-ND-23	1.00	ZYGLO INSP LARGE PART BLD507,		.17130		.190	
0020 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC,		.01001		.011	
9000		DB 01 00		.01	LABOR STD HISTORY	.000	.000	.000	0
0010				20NOV85 REMOTE STD TO MATCH 958 <OLD STD .96>					
0020				20MAY87-DELETED SUBOP 0085 NOT DONE OLD STD .46					
0900				KERRY COOP MANEAA TECHN 73357					

O INTERROGATE LABOR STANDARDS, INPUT

RCC PRO NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

15139A B52 M WHL 3-1192

RCC MNPNA

4W1-7-1143

ER TECH S S W F PF A/R REV

SUB	T K	NR A FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A	
STEP D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
4105	S E	DB EA 2	J 88301	1.00	PERCENT ENGR 99.9	NDI WHEEL HALF INBD. B-52M.	.01		.01	
0001		DB 01	00	.00		PART NO. / N.S.N.	.000	.000	.000	0
0010					300-254	N.S.L.				
0020					300-254-1	1630010009667				
0085		DB 01	11	.05		FPI	.171	.001	.010	.8 50
0010 E			ZLG-ND-23	1.00	ZYGLD INSP LARGE PART BLD507		.17130		.190	
0160		DB 01	11	.05		FPI	.171	.001	.010	.8 50
0010 E			ZLG-ND-23	1.00	ZYGLD INSP LARGE PART BLD507		.17130		.190	
		DB 01	00	.01		LABOR STD HISTORY	.000	.000	.000	0
0010					20NOV85 REWROTE STD TO MATCH 958 <OLD STD .96>					
0020					20MAY87-DELETED SUBOP 0085 NOT DONE OLD STD .46					
0900					KERRY COOP MANEAA TECHN 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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15139A B52 M WHEEL 3-1192

RCC MPRA

4M1-7-1143 900-9739

ER TECH S S W F PF A/R REV

SUB	T K	#R	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A				
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT	C
102	S	E	JA	EA	1	J 88302	1.00 PERCENT ENGR 99.9	MACH. B52M. WHL. OUTBOARD		1.34		1.34			
0001			JA	01	00		.00	PART NO. / N.S.N.		.000	.000	.000			0
0010							300-255	N.S.L.							
0020							300-255-1	1630011112990							
0010			JA	01	15		.07	REM BEARING BORE BUSH, LARGE		.846	.009	.068			5
0010	E					RML-SU-V3	.25 S/U VERT MIL BORE FXTR HOIST PRORATE OVER 8 PARTS			1.03687		.298			
0020	E					RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP	JIG BORE		.15776		.181			
0030	E					RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD			.12699		.146			
0040	E					RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD			.07609		.087			
0050	E					KMM-BA-LB	1.00 BORE HOLE 6 X 1 GROUP 1			.21626		.248			
0060	E					RJP-PW-R1	1.00 REM RPL PAPR MARK SIGN OFF DOC			.01001		.011			
0060			JA	01	15		.05	MACHINE MATTING SURFACE		.263	.002	.015			1
0010	E					RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS			.49962		.143			
0020	E					RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK			.01006		.011			
0030	E					KML-TA-JC	1.00 DIA 5.00-6.00 REM .033-.250			.09193		.105			
0040	E					KML-TA-JD	1.00 DIA 6.0 REM .250 ADD INCH			.02665		.030			
0050	E					RJP-PW-R1	1.00 REM RPL PAPR MARK SIGN OFF DOC			.01001		.011			
0070			JA	01	15		.05	VALVE STEM HOLE REP RAD DR		.459	.003	.026			2
0010	E					RDR-SU-R1	.25 S/U TO O/S BOSSES RAD DRILL PRORATE OVER 8 PARTS			.56378		.162			
0020	E					RDR-BO-A1	1.00 O/S BOSS W/STEP RMR RAD DRL			.30463		.350			
0030	E					RBW-DB-A1	1.00 DEBUR HOLE/CUTOUT BOTH SIDES			.00423		.004			
0040	E					RJP-PW-R1	1.00 REM RPL PAPR MARK SIGN OFF DOC			.01001		.011			
0090			JA	01	15		.05	REP TIE BOLT HOLE, RAD DRILL		4.658	.035	.268			20

0010 E	RDR-SU-R1	.25 S/U TO O.S. BOSSES RAD DRILL PRORATE OVER 8 PARTS	.56378	.162	
0020 E	RDR-BO-A1	1.00 O/S BOSS W/STEP RMR RAD DRL	.30463	.350	
0030 E	RDR-BO-A2	26.00 O/S ADNL BOSS STP RMR RAD OCCURANCE = NUMBER OF HOLES	.14687	4.391	
0040 E	KAL-SM-31	27.00 SPOT-FACE OR COUNTERBORE OCC. FOR NO. OF HOLES	.00423	.131	
0050 E	RBN-DB-A1	27.00 DEBUR HOLE/CUTOUT BOTH SIDES OCC. FOR NO. OF HOLES	.01001	.310	
0060 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0150	JA 01 15	.05 BEARING BORE SEAT REP, MED	.812	.006	.047 3
0010 E	RML-SU-V2	.25 S/U VERT MILL BORE LRG FIXTRPRORATE OVER 8 PARTS	.80167	.230	
0020 E	RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP JIG BORE	.15776	.181	
0030 E	RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD	.12699	.146	
0040 E	RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD	.07609	.087	
0050 E	RML-BA-LB	1.00 BORE HOLE 6 X 1 GROUP 1	.24122	.277	
0060 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0160	JA 01 15	.07 BEARING BORE REP - JIG BORE	.812	.009	.065 5
0010 E	RML-SU-V2	.25 S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS	.80167	.230	
0020 E	RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP	.15776	.181	
0030 E	RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD	.12699	.146	
0040 E	RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD	.07609	.087	
0050 E	RML-BA-LB	1.00 BORE HOLE 6 X 1 GROUP 1	.24122	.277	
0060 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0180	JA 01 15	.07 BRNG. BORE LK. RG. GROOVE	.597	.006	.048 4
0010 E	RML-SU-V2	.25 S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS	.80167	.230	
0020 E	RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP	.15776	.181	
0030 E	RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD	.12699	.146	
0040 E	RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD	.07609	.087	
0050 E	KML-TA-JD	1.00 DIA 6.0 REM .250 ADD INCH	.02665	.030	
0060 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0190	JA 01 15	.05 CRACKED WHEEL W. HOLE	.459	.003	.026 2
0010 E	RDR-SU-R1	.25 S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS	.56378	.162	
0020 E	RDR-BO-A1	1.00 O/S BOSS W/STEP RMR RAD DRL	.30463	.350	

0030 E	RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423	.004	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
JA 01 15		.05	CRACKED TIME C. HOLE	.459	.003	.026 2
0010 E	RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS	.56378	.162	
0020 E	RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL	.30463	.350	
0030 E	RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423	.004	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
0250 JA 01 15		.05	INST TIE BOLT BUSHING	.613	.005	.035 3
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 8 PARTS	.18669	.053	
0020 E	RBW-BU-A4	27.00	INSTALL ONE STRAIGHT BUSHING OCC. FOR NO. OF BUSHINGS	.02062	.640	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
0260 JA 01 15		.61	INST CUP INTO BUSHING	.077	.007	.054 4
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
JA 01 15		.61	MACH BEARING BORE BUSHING	.236	.022	.166 12
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 8 PARTS	.49962	.143	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006	.011	
0030 E	KML-TA-JC	1.00	DIA 5.00-6.00 REM .033-.250	.09193	.105	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
0270 JA 01 15		.61	INST BEARING BORE BUSH & CUP	.077	.007	.054 4
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 8 PARTS	.18669	.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
0280 JA 01 15		.05	INST CUP INTO BUSHING	.077	.001	.004 0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
0285 JA 01 15		.05	MACH.OD OF BUSH. CUP ASSY.	.547	.004	.031 2
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962	.143	



0020	E	RLA-HP-C1	1.00	1ST PART ...-OUT SCROLL CHUCK	.01006	.011	
0030	E	KML-TD-JC	1.00	DIA 5.00-6.00 REM .033-.250	.40208	.462	
40	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0290	JA 01	15	.05	INST BEARING BORE BUSH & CUP	.077	.001	.004 0
0010	E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 8 PARTS	.18669	.053	
0020	E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0330	JA 01	15	1.00	INSTALL HELICOILS	.348	.052	.401 30
0010	E	RBW-SU-H1	1.00	SET UP TO INSTALL HELICOILS	.31093	.357	
0020	E	RBW-TR-H1	1.00	INSTALL HELICOIL INSERT	.02763	.031	
0030	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
9000	JA 00	15	.00	LABOR STANDARD HISTORY	.000	.000	.000 0
0001				06MAY85 MATCHED WITH 958 FOR OUTBD HALF			
0002				AND AS PER OCC.FACT.STUDY.NEW OP NO.			
0003				AUG85 ADDED PF&D TIME TO E STDS. (TM WAS 2.26)			
0004				21OCT85 2 YEAR REVIEW			
0005				BAUG86 IMPLEMENTED TIME STUDIES COMPLETED ON			
0006				SUBOP 0110/ WORK PREVIOUSLY WORKED ON OPERATION			
0007				M0010 (OLD STD 2.38)			
0008				LDEC86 CHANGED SUB-OPP0090 DUEPTO A METHODS			
0009				IMPROVEMENT (OLD STD 1.66)			
0010				20MAY87-DELETED SUBOP'S 0080/0110 OLD STD 1.59			
0011				6 NEW SUBOPPS ADDED OLD TIME WAS 1.10			
0900				KERRY COOP MANEL TECHN 73357			

TO " " PROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

15139A BS2 M WHEEL 3-1192

RCC MPRA

4M1-7-1143 900-9739

PER TECH S S W F PF A/R REV

SUB	T K	#R A	FA SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A	
STEP D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C

RA105	S	E	JA	EA 1	J 88300	.65 PERCENT ENGR 92.6	MACH. B-52M. WHEEL INBD.	2.19	1.42		
0001			JA	01	00	.00	PART NUMBER / N.S.N.	.000	.000	.000	0
			0010			300-254	N.S.L.				
			0020			300-254-1	1630011119667				
0010			JA	01	15	.05	REMV DR. KEY INDEX BUSHING	.669	.005	.039	2
0010	E				GJP-TL-A1	1.00 JOB PREPARATION GENERAL		.11960		.137	
0020	N					9.00	REMOVE KEY BUSH. OCC. 9EA.	.06000		.621	
0030	E				RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
			JA	01	15	.46	REM BEARING BORE BUSH, LARGE	.863	.060	.457	21
0010	E				RML-SU-V3	.25 S/U VERT MIL BORE FXTR HOIST PRORATE OVER 8 PARTS		1.03687		.298	
0020	E				RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP JIG BORE		.15776		.181	
0030	E				RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E				RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E				KPM-BA-LB	1.00 BORE HOLE 6 X 1 GROUP 1 USE PROPER ELEMENT/TABLE		.23311		.268	
0060	E				RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0050			JA	01	15	.05	FUSE PLUG HOLE REPAIR	.753	.006	.043	2
0010	E				RDR-SU-R1	.25 S/U TO O/S BOSSES RAD DRILL PRORATE OVER 8 PARTS		.56378		.162	
0020	E				RDR-BO-A1	1.00 O/S BOSS W/STEP RMR RAD DRL		.30463		.350	
0030	E				RDR-BO-A2	2.00 O/S ADML BOSS STP RMR RAD DROCCURRANCE = NUMBER OF HOLES		.14687		.337	
0040	E				RBW-DB-A1	1.00 DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004	
0050	E				RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0060			JA	01	15	.05	MACH. MATTING SURFACE	.459	.003	.026	1
0010	E				RDR-SU-R1	.25 S/U TO O/S BOSSES RAD DRILL PRORATE OVER 8 PARTS		.56378		.162	

0020 E	RDR-BQ-A1	1.00	O/S BOSS W/STEP RMR RAD DRL	.30463	.350		
0030 E	RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423	.004		
40 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011		
0070	JA 01	15	.05	SPOT FACE TIE BOLT HOLES	.722	.005 .042	2
0010 E	RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 8 PARTS	.56378	.162		
0020 E	RML-HP-H1	1.00	PART ON/OFF MACH HAND NO RAP,	.03068	.035		
0030 E	KAL-SM-J1	27.00	SPOT-FACE OR COUNTERBORE OCC. FOR 27 FACES	.02004	.622		
0040 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC,	.01001	.011		
0080	JA 01	15	.05	REP TIE BOLT HOLE,RAD DRILL	4.278	.032 .246	11
0010 E	RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 8 PARTS	.56378	.162		
0020 E	RDR-BQ-A1	1.00	O/S BOSS W/STEP RMR RAD DRL	.30463	.350		
0030 E	RDR-BQ-A2	26.00	O/S ADML BOSS STP RMR RAD DROCC. FOR 26 HOLES	.14687	4.391		
0040 E	RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423	.004		
0050 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011		
0087	JA 01	15	.05	BEARING BORE SEAT REP,LARGE	.846	.006 .049	2
0010 E	RML-SU-V3	.25	S/U VERT MIL BORE FXTR HOISTPRORATE OVER 8 PARTS	1.03687	.298		
0020 E	RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP JIG BORE	.15776	.181		
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699	.146		
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609	.087		
0050 E	KML-TD-JC	1.00	DIA 5.00-6.00 REM .033-.250	.21626	.248		
0060 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011		
0090	JA 01	15	.46	BEARING BORE REP,PENSOTTI	.508	.035 .269	12
0010 N		1.00	SET UP PENSOTTI	.16700	.192		
0020 E		1.00	4 .26 MACHINE BEARING BORE	.29333	.337		
0030 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC/	.01001	.011		
0040 E	RPL-MH-P1	1.00	GET PALLET JACK & MOVE PARTS/	.03815	.043		
0100	JA 01	15	.05	DRIVE KEY HOLE REP RAD DRL	2.930	.022 .169	8
0010 E	RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 8 PARTS	.56378	.162		
0020 E	RDR-BQ-A1	9.00	O/S BOSS W/STEP RMR RAD DRL OCC. = 9 HOLES	.30463	3.152		
0030 E	RBW-DB-A1	9.00	DEBUR HOLE/CUTOUT BOTH SIDES OCC. = 9 HOLES	.00423	.043		

0040 E	RJP-PW-R1	1.00	REM RPL F. MARK SIGN OFF DOC	.01001	.011	
0110	JA 01 15	.07	MACH. DVE. KEY INDEX HOLES	2.930	.031	.236 11
.0 E	RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 8 PARTS	.56378	.162	
0020 E	RDR-BO-A1	9.00	O/S BOSS W/STEP RMR RAD DRL OCC. = 9 HOLES	.30463	3.152	
0030 E	RBW-DB-A1	9.00	DEBUR HOLE/CUTOUT BOTH SIDES OCC. = 9 HOLES	.00423	.043	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
0120	JA 01 15	.46	MACHINE ID KEY SEAT AREA TO	.487	.034	.258 12
0001			REMOVE CORROSSION			
0010 N		1.00	SET UP PENSOTTI	.08000	.092	
0020 E		2.50 3	.53 B52 MLG MHL HLF KEY SEAT	.14383	.413	
0021			REPAIR 1 CUT PENSOTTI/OCC AT 2.50/1 TO 4 CUTS/			
0030 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC/	.01001	.011	
0040 E	RPL-MH-P1	1.00	GET PALLET JACK & MOVE PARTS/	.03815	.043	
0140	JA 01 15	.05	BRNG. BORE LOCK RING GROOVE	.787	.006	.045 2
0010 E	RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS	.80167	.230	
0020 E	RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP	.15776	.181	
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699	.146	
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609	.087	
0050 E	KML-TA-JD	1.00	DIA 6.0 REM .250 ADD INCH	.21626	.248	
0060 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
0150	JA 01 15	.05	CRACKED WHEEL W. HOLE	.459	.003	.026 1
0010 E	RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS	.56378	.162	
0020 E	RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL	.30463	.350	
0030 E	RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423	.004	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
0155	JA 01 15	.05	CRACKED TIME C. HOLE	.459	.003	.026 1
0010 E	RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS	.56378	.162	
0020 E	RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL	.30463	.350	
0030 E	RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423	.004	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	

0200	JA 01	15	.05	INST TIE BOLT HOLE BUSHINGS	.677	.005	.039	2
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 8 PARTS	.18669		.053	
0020 E	RBW-BU-A2	27.00	INSTALL SET STRAIGHT BUSHING OCC. FOR 27 BUSHINGS		.02299		.713	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0204	JA 01	15	.05	INST CUP INTO BUSHING	.077	.001	.004	0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0208	JA 01	15	.05	MACH BEARING BORE BUSHING	.236	.002	.014	1
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 8 PARTS	.49962		.143	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030 E	KML-TA-JC	1.00	DIA 5.00-6.00 REM .033-.250		.09193		.105	
0040 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0210	JA 01	15	.05	INST BEARING BORE BUSH & CUP	.077	.001	.004	0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 8 PARTS	.18669		.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0212	JA 01	15	.05	INST CUP INTO BUSHING	.077	.001	.004	0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0216	JA 01	15	.05	TURN BUSHING GROUP 4/STEEL	.547	.004	.031	1
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030 E	KML-TD-JC	1.00	DIA 5.00-6.00 REM .033-.250		.40208		.462	
0040 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0220	JA 01	15	.05	INST BEARING BORE BUSH & CUP	.077	.001	.004	0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 8 PARTS	.18669		.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	

1225	JA 01	15	.05	TURN BUSHING GROUP 4/STEEL	1.206	.009	.069	3
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E	RLA-HP-C1	9.00	1ST PART IN-OUT SCROLL CHUCK OCC. FOR 9 BUSHINGS		.01006		.104	
0030 E	KML-TD-CC	9.00	DIA .501-1.00 REM .033-.250 OCC. FOR 9 BUSHINGS		.10898		1.127	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
1230	JA 01	15	.05	INSTALL KEY B.HOLE BUSH.	.242	.002	.014	1
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RBW-BU-A4	9.00	INSTALL ONE STRAIGHT BUSHING OCC FOR 9 BUSHINGS		.02062		.213	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
1235	JA 01	15	.05	TURN BUSHING GROUP 4/STEEL	1.206	.009	.069	3
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E	RLA-HP-C1	9.00	1ST PART IN-OUT SCROLL CHUCK OCC. FOR 9 BUSHINGS		.01006		.104	
0030 E	KML-TD-CC	9.00	DIA .501-1.00 REM .033-.250 OCC. FOR 9 BUSHINGS		.10898		1.127	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
1240	JA 01	15	.05	INST STRAIGHT BUSH NO POLISH	.242	.002	.014	1
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RBW-BU-A4	9.00	INSTALL ONE STRAIGHT BUSHING OCC. FOR 9 BUSHINGS		.02062		.213	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
000	JA 00	15	.00		.000	.000	.000	0

0001 07MAY85 DIV WHL INTO 2 OP.&MATCHED WITH

0002 958 AND C/W OCC FAC STUDY (TH WAS 5.80)

0003 13MAY85 DELETED SUB OPS 10,20,30,40,DHPL

0004 AUG85 ADDED PF&D TIME TO E STDS (TH WAS 1.28)

0005 21OCT85 2 YEAR REVIEW

0006 BAUG86 IMPLEMENTED TIME STUDIES COMPLETED ON

0007 SUBOPS 0100 & 0140/ WORK PREVIOUSLY WORKED ON

0008 OPERATION M0020/ (OLD STD 1.21)

0009 1DEC86 CHANGED SUB-OP 0070 DUE TO A METHODS

0010 IMPROVEMENT (OLD STD 1.41)

0011 NEW SUBOPPS ADDED 0010/0011REMOVE BUSHINGS

0012

OCC.FAC: RELEASED FOR 27 BUSH.&

0900

KERRY COOP MANEL TECHN 73357

INTERROGATE LABOR STANDARDS, INPUT

CC PRD NRDP NR

--X--X-->

34567890123456 ELSE PUT IN END

15139A BS2 MLG WHL 3-1192

RCC MNPRC

4W1-7-1143 900-9739 81157

PER TECH S S W F PF A/R REV

SUB	T K	HR A FA	SUPPORT	DCC	DESCRIPTION	BASE	PFD	STD	A	
STEP D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
C102	S	E	UP	EA B	J 88302	1.00 PERCENT ENGR 96.8	B-52M.WHEEL HALF OUTBOARD	1.98	1.98	
0001		UP	01	00		.00	PART NO. / N.S.N.	.000	.000	.000 0
0010						300-255	N.S.L.			
0020						300-255-1	1630011112990			
0225		UP	01	24		1.00	DEGREASE	.150	.036	.187 9
0010 E						RPL-DE-L1	1.00 DEGREASE LARGE PART OR BASKT	.14095	.174	
0020 E						RJP-PW-R1	1.00 REM RPL PAPRMRK SIGN OFF DOC	.01001	.012	
0230		UP	01	24		1.00	SHOTPEEN LARGE PART/MASK	.848	.204	1.052 53
0010 E						ZMA-CL-04	1.00 MASK V/LRG CYL TYPE PART	.32667	.405	
0020 E						RPL-SP-L1	1.00 SHOT PEEN LARGE PART	.46073	.571	
0030 N						ZUM-CL-02	1.00 UNMASK MEDIUM SIZE CYL PART	.05067	.062	
0040 E						RJP-PW-R1	1.00 REM RPL PAPRMRK SIGN OFF DOC	.01001	.012	
0240		UP	01	24		1.00	ANODIZE LARGE PART	.604	.145	.749 .8 38
0010 E						RWB-CV-D1	1.00 VAPOR CL (DEGR)HOOK/BASKET	.08709	.107	
0020 E						ZPL-AN-L1	1.00 ANODIZE LARGE SIZE PART	.50714	.628	
0030 E						RJP-PW-R1	1.00 REM RPL PAPRMRK SIGN OFF DOC	.01001	.012	
9000		UP	01	24		.01	LABOR STD HISTORY	.000	.000	.000 0
0010							ZONOV85 WROTE STD TO MATCH 958 (NEW STD)			
0900							KERRY COOP MANEAA TECHN 73357			

TO INTERROGATE LABOR STANDARDS, INPUT



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34567890123456 ELSE PUT IN END

ARC105

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

15139A B52 MLG WHL 3-1192

RCC MNPAC

4W1-7-1143 900-9739 81157

PER TECH S S W F PF A/R REV

SUB T K #R A FA SUPPORT OCC <----- DESCRIPTION -----> BASE PFD STD A

STEP D L K C DC ELEMENT FACT STORED SUPPLEMENTAL HOURS TIME HOURS DLY PCT C

C105	S	E	UP	EA	B	J	88301	1.00	PERCENT ENGR 96.8	B-52 MAIN WHL.HALF INBD.	1.98		1.98		
0001			UP	01	00			.00		PART NO. / N.S.N.	.000	.000	.000		0
0010									300-254	N.S.L.					
0020									300-254-1	1630011119667					
0170			UP	01	24			1.00		DEGREASE	.150	.036	.187		9
0180	E								RPL-DE-L1	1.00 DEGREASE LARGE PART OR BASKT	.14095		.174		
0020	E								RJP-PW-R1	1.00 REM RPL PAPMRK SIGN OFF DOC	.01001		.012		
0180			UP	01	24			1.00		SHOTPEEN LARGE PART/MASK	.848	.204	1.052		53
0010	E								ZMA-CL-04	1.00 MASK V/LRG CYL TYPE PART	.32667		.405		
0020	E								RPL-SP-L1	1.00 SHOT PEEN LARGE PART	.46073		.571		
0030	N								ZUM-CL-02	1.00 UNMASK MEDIUM SIZE CYL PART	.05067		.062		
0040	E								RJP-PW-R1	1.00 REM RPL PAPMRK SIGN OFF DOC	.01001		.012		
0190			UP	01	24			1.00		ANODIZE LARGE PART	.604	.145	.749	.8	38
0010	E								RWB-CV-D1	1.00 VAPOR CL (DEGR)HOOK/BASKET	.08709		.107		
0020	E								ZPL-AN-L1	1.00 ANODIZE LARGE SIZE PART	.50714		.628		
0030	E								RJP-PW-R1	1.00 REM RPL PAPMRK SIGN OFF DOC	.01001		.012		
9000			UP	01	24			.01		LABOR STD HISTORY	.000	.000	.000		0
0010										20NDV85 WROTE STD TO MATCH 958 <NEW STD>					
00										KERRY COOP MANEAA TECHN 73357					

139A BS2 M WHEEL 3-1192

RCC MNPGP

4W1-7-1143 900-9739 81043

3 TECH S S W F PF A/R REV

SUB	T K	#R A	FA SUPPORT	OCC	DESCRIPTION	BASE	PF0	STD	A	
STEP D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C

10	S	E	YH	EA 5	J 88300	1.00 PERCENT ENGR 99.9	ASSY. WHEEL 8-52 M.	2.00		2.00	
0001			YH	01	00	.00	PART NO. / N.S.N.	.000	.000	.000	0
			0010			3-1192	1630009009739				
			0020			3-1192-1	1630012286043				
0015			YH	01	21	1.00	ASSEMBLE WHEEL	1.654	.348	2.002	100
			0005	E		RWB-QH-W2 2.00	REMY WHL HLF F/PAINT CONVMORZ WHEEL HALVES	.00833		.020	
			0010	E		RWB-JP-W2 1.00	PREP TO ASSY DR DISSY WHEEL	.00442		.005	
			0011	E		RWB-FW-S3 1.00	FINAL CK-INSP PARTS	.19577		.236	
			0020	E		RWB-BC-03 2.00	INSTALL BEARING CUPS	.16838		.407	
			0030	E		RWB-BB-01 2.00	BALANCE WHEEL HALF	.07734		.187	
			0040	E		RWB-UP-P8 1.00	UNPK PARTS-BK KEY-TIE BOLT	.08482		.102	
			0050	E		RWB-AW-T1 27.00	INSTL UNOBSTRUCTED TIE BOLT	.00975		.318	
			0060	E		RWB-AW-K2 9.00	INSTL BRAKE KEY/MULTI-SCREW	.01642		.178	
			0070	E		RWB-AW-TF 3.00	REPLACE THERMAL FUSES	.06162		.223	
			0080	E		RWB-AW-B1 2.00	INSTL BEARNG/SNAP RING SECURD	.02459		.059	
			0100	E		RWB-AW-H3 1.00	INSTL SINGLE PC HEAT SHIELD	.00360		.004	
			0110	E		RWB-NB-02 2.00	PROC TIME NCK / BUR LG PART	.04733		.114	
			0120	E		RWB-FT-01 1.00	FINAL & TUCH UP V/L LRG WHEL	.10838		.131	
			0130	E		RJP-PW-R1 1.00	REM RPL PAPRMK SIGN OFF DOC	.01001		.012	
9000			YH	01	21	.00	LABOR STANDARD HISTORY	.000	.000	.000	0

0010 06JUN84 ADD SUB OP 0001 & UNLOAD LINE<OLD STD> 1.85

0020 26MAR85 2 YEAR REV NO CHNG (OLD TM 1.93)

0021 3MAR86 CHANGED SKILL CODE FROM Y6 TO YH

0022

NO TIME CHANGE

0023

20CT86 2 YEAR REVIEW, DELETED STEP 0140 SUBOP

24

0010 WORK DONE BY DS PERSONNEL <OLD STD 1.93>

0900

KERRY COOP MANEL TECHN 73357

0 INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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.234567890123456 ELSE PUT IN END

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MMI-DY-M45 PAGE 0001

.5139A B52 M WHEEL 3-1192

RCC MNPGR

4W1-7-1145 900-9739 81043

ER TECH S S W F PF A/R REV

SUB	T K	NR A FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A	
STEP	D L	K C	DC ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C

1106	S	E	YH	EA 5	J 88300	1.00 PERCENT ENGR 84.5	MATCH UP WHEEL B52M.	.13		.13	
0001			YH	01	00	.00	PARTS NO. / N.S.N.	.000	.000	.000	0
0010						3-1192	1630009009739				
0020						3-1192-1	1630012286043				
0010			YH	01	21	1.00	WHEEL MATCH UP	.110	.023	.134	100
0010	E					MGT-EE-24	1.00 GET EASY AND PLACE EXACT	.00097		.001	
0020	E					RWB-UP-P7	1.00 UNPK PARTS-BK KEY-SNAP RING	.08237		.099	
0030	M						1.00 MATCH WHEEL HALFS 2 HALFS	.01700		.020	
0040	E					RJP-PW-R1	1.00 REM RPL FAPRWRK SIGN OFF DOC	.01001		.012	
9000			YH	01	21	.00	LABOR STANDARD HISTORY	.000	.000	.000	0
0010							06JUN84 ADD SUB OP 0001 & UNLOAD LINE<OLD STD> 1.85				
0020							26MAR85 2 YEAR REV NO CHNG (OLD TM 1.93)				
0021							3MAR86 CHANGED SKILL CODE FROM Y6 TO YH				
0022							NO TIME CHANGE				
0023							20CT86 2 YEAR REVIEW, DELETED STEP 0140 SUBOP				
0024							0010 WORK DONE BY DS PERSONNEL <OLD STD 1.93>				
0900							KERRY COOP MANEL TECHN 73357				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

7MPPGP15139APP106

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 04/26/89 A-E046B-MM1-DY-M45 PAGE 0001  
RCC MPPGP 4M1-7-1143 900-9739 81043

15139A B52 M WHEEL 3-1192										RCC MPPGP		4W1-7-1143 900-9739		81043							
TECH S S W F PF A/R REV																					
T K #R A FA SUPPORT OCC <----->										DESCRIPTION <----->		BASE		PFD		STD		A			
STEP D L K C DC ELEMENT FACT										STORED		SUPPLEMENTAL		HOURS		TIME		HOURS		DLY PCT C	
PP106 S E 3S EA 5 J 89116 1.00 PERCENT ENGR 99.9										TOUCH-UP PAINT B-52M WHL		.07				.07					
0001 3S 01 00 .00										PARTS NO. / N.S.N.		.000		.000		.000				0	
0010 3-1192										1630009009739											
0020 3-1192-1										1630012286043											
0020 3S 01 25 1.00										PAINT TOUCH UP SM & MED		.063		.016		.080				100	
0010 E RNB-FT-02 1.00 FINAL & TUCH UP MED/SM L WHEL												.05395				.067					
0020 E RJP-PW-R1 1.00 REM RPL PAPMARK SIGN OFF DOC												.01001				.012					
9000 3S 01 00 .00										LABOR STANDARD HISTORY		.000		.000		.000				0	
0010 26 APR 89 INITIAL INPUT MRP11																					
0900 BOB ROSS MANEL-1 77126																					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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1234567890123456 ELSE PUT IN END

15139A B52 M WHEEL 3-1102

RCC MNPGP

4W1-7-1143 900-9739 81043

PER TECH S S W F PF A/R REV

SUB T K NR A FA SUPPORT OCC &lt;----- DESCRIPTION -----&gt; BASE PFD STD A

STEP D L K C DC ELEMENT FACT STORED SUPPLEMENTAL HOURS TIME HOURS DLY PCT C

P102	S	E	3S	EA	5	J	88302	1.00	PERCENT ENGR 99.9	PAINT WHEEL HALF 8-52M.	.33		.33		
0001			3S	01	00			.00		PART NO. / N.S.N.	.000	.000	.000	0	
0010								300-255		N.S.L.					
0020								300-255-1		1630011112990					
0360			3S	01	25			1.00		PAINT WHEEL	.267	.067	.334	4.0	100
0010	E							4.00	INST NONTHEADED PLSTC PLUG		.00093		.004		
0020	E							1.00	MASK & UNMASK MEDIUM PART		.01242		.015		
0030	E							1.00	HANG WHL HLF ON PAINT CONVYR		.02336		.029		
0040	E							1.00	PNT WHL HALF-ZINC CHROMATE		.11574		.144		
0050	E							1.00	PNT WHL HALF (2ND COAT)	POLY 2 COATS	.10214		.127		
0060	E							1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012		
9000			3S	01	25			.00		LABOR STANDARD HISTORY	.000	.000	.000	0	
0010									06JUN84 REMOVE UNLOADING PAINT LINE <OLD STD>	.57					
0020									26MAR85 2 YEAR REV.NO CHNG (OLD TM .55)						
0021									20CT86 2 YEAR REVIEW DELETED STEP 0060 WORK						
0022									PERFORMED BY DS PERSONNEL <OLD STD .55>						
0900									KERRY COOP MANEL TECHN 73357						

TO PROPGATE LABOR STANDARDS, INPUT

RCC PRO NROP NR

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

5139A B52 M WHEEL 3-1192

RCC MNPGP

4M1-7-1143 900-9739 81043

JR TECH S S W F PF A/R REV

SUB	T K	NR	A FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A	
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
105	S	E	3S	EA 5	J 88301	1.00 PERCENT ENGR 99.9	PAINT WHEEL HALF B-52M	.33		.33	
0001			3S	01	00	.00	PART NO. / N.S.N.	.000	.000	.000	0
0010						300-254	N.S.L.				
0020						300-254-1	1630010009667				
0280			3S	01	25	1.00	PAINT WHEEL	.267	.067	.334	4.0 100
0010 E						6PL-PA-01	4.00 INST NONTHEADED PLSTC PLUG	.00093		.004	
0020 E						GIG-SP-M1	1.00 MASK & UNMASK MEDIUM PART	.01242		.015	
0030 E						RWB-OH-W1	1.00 HANG WHL HLF ON PAINT CONVR	.02336		.029	
40 E						RWB-SC-02	1.00 PNT WHL HALF-ZINC CHROMATE	.11574		.144	
0050 E						RWB-SC-P3	1.00 PNT WHL HALF (2ND COAT) POLY 2 COATS	.10214		.127	
0060 E						RJP-PW-R1	1.00 REM RPL PAPMRK SIGN OFF DOC	.01001		.012	
9000			3S	01	25	.00	LABOR STANDARD HISTORY	.000	.000	.000	0
0010							06JUN84 REMOVE UNLOADING PAINT LINE <OLD STD> .57				
0020							26MAR85 2 YEAR REV.NO CHNG (OLD TM .55)				
0021							20OCT86 2 YEAR REVIEW DELETED STEP 0060 WORK				
0022							PERFORMED BY DS PERSONNEL <OLD STD .55>				
0900							KERRY COOP MANEL TECHN 73357				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

5139A B52 M WHEEL 3-1192

RCC MNP6P

4W1-7-1143 900-9739 81043

ER TECH S S W F PF A/R REV

SUB	T K	#R A	FA SUPPORT	DDC	DESCRIPTION	BASE	PFD	STD	A
STEP D L	K C	DC ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
106	E	N 3S	EA 5	J 88300	1.00 PFRCENT ENGR 46.6	PAINT WHEEL B-52M	.48	.48	
0001		3S 01	00		.00	PART NO. / N.S.N.	.000	.000	.000
0010				3-1192	1630009009739				
0020				3-1192-1	1630012286043				
0020		3S 01	25		1.00	PAINT TOUCH UP V/L LGE	.118	.030	.148
0010 E				RWB-FT-01	1.00 FINAL & TUCH UP V/L LRG WHEL		.10838	.135	
0020 E				RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001	.012	
0997		3S 01	25		1.00	FINAL ACCEPTANCE OF W.C.D.	.132	.033	.166
0010 N					1.00	FINAL	.08000	.100	
0020 E				GJP-FP-85	1.00	FILL OUT FORM 424 & ATTACH	.05255	.065	
0998		3S 01	25		1.00	FINAL VISUAL INSPECTION	.137	.034	.171
0010 N					1.00	FINAL VISUAL INSPECTION	.12700	.158	
0020 E				RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001	.012	
9000		3S 01	25		.00	LABOR STANDARD HISTORY	.000	.000	.000
0010					06JUN84 REMOVE UNLOADING PAINT LINE <OLD STD> .57				
0020					26MAR85 2 YEAR REV.NO CHNG (OLD TH .55)				
0021					20CT86 2 YEAR REVIEW DELETED STEP 0060 WORK				
0022					PERFORMED BY DS PERSONNEL <OLD STD .55>				
0900					KERRY COOP MANEL TECHN 73357				

TO INTERROGATE LABOR STANDARDS, INPUT



15139A B52 M WHEEL 3-1192

RCC MNPSP

4W1-7-1143 900-9739 81043

PER TECH S S W F PF A/R REV

SUB	T K	#R A	FA	SUPPORT	DOC	DESCRIPTION	BASE	PFD	STD	A	
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
S102	S	E	YH	EA 5	J 88302	1.00 PERCENT ENGR 95.9	PRE. INSP. & ASSY. WHL. HLF. B52M.	.50		.50	
0001		YH	01	00		.00	PART NO. / N.S.L.	.000	.000	.000	0
0010						300-255	N.S.L.				
0020						300-255-1	1630011112990				
0350		YH	01	21		1.00	PREINSPECTION WHEEL HALF	.015	.003	.019	4
0010 E					RWB-JP-W2	1.00 PREP TO ASSY OR DISSY WHEEL		.00442		.005	
0020 E					KAL-GC-46	1.00 INSPECT VISUAL		.00115		.001	
0030 E					RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
		YH	01	21		1.00	RACE INSTALLATION WHL/HALF	.178	.037	.216	43
0010 E					RWB-BC-03	1.00 INSTALL BEARING CUPS		.16838		.203	
0020 E					RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
0370		YH	01	21		1.00	BALANCE WHEEL HALF	.111	.023	.134	27
0010 E					GPL-PD-01	4.00 REM NONTHEADED PLASTIC PLUG		.00339		.016	
0020 E					GMC-MT-D1	1.00 REMOVE MASKING TAPE		.00191		.002	
0030 E					RWB-DH-W2	1.00 REMV WHL HLF F/PAINT CONVOYOR		.00833		.010	
0040 E					RWB-BB-01	1.00 BALANCE WHEEL HALF		.07734		.093	
0050 E					RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
0380		YH	01	21		1.00	WHEEL MATCH UP	.110	.023	.134	27
0010 E					MST-EE-24	1.00 GET EASY AND PLACE EXACT		.00097		.001	
0020 E					RWB-UP-P7	1.00 UNPK PARTS-BK KEY-SNAP RING		.08237		.099	
0030 N						1.00	MATCH WHEEL HALFS 2 HALFS	.01700		.020	
0040 E					RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
9000		YH	01	21		.00	LABOR STANDARD HISTORY	.000	.000	.000	0

0010 06JUN84 SUB OP 0001 &UNLOAD LINE<OLD STD> 1.85  
0020 26MAR85 2 YEAR REV NO CHNG (OLD TM 1.93)  
21 3MAR86 CHANGED SKILL CODE FROM Y6 TO YH  
0022 NO TIME CHANGE  
0023 20CT86 2 YEAR REVIEW, DELETED STEP 0140 SUBOP  
0024 0010 WORK DONE BY DS PERSONNEL <OLD STD 1.93>  
0900 KERRY COOP MANEL TECHN 73357

J INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

--X--X-->

.234567890123456 ELSE PUT IN END

.5139A B52 M WHEEL 3-1192

RCC MNPBP

4W1-7-1143 900-9739 81043

ER TECH S S W F PF A/R REV

SUB	T K	#R A	FA	SUPPORT	QCC	DESCRIPTION	BASE	PFD	STD	A	
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
3105	S	E	YH	EA 5	J 88301	1.00 PERCENT ENGR 95.9	PRE.INSPECT&ASSY WHL.H.B52M	.50		.50	
0001		YH	01	00		.00	PART NO. / N.S.N.	.000	.000	.000	0
0010						300-254	N.S.L.				
0020						300-254-1	1630010009667				
0270		YH	01	21		1.00	PREINSPECTION WHEEL HALF	.015	.003	.019	4
0010 E					RWB-JP-W2	1.00 PREP TO ASSY OR DISSY WHEEL		.00442		.005	
0020 E					KAL-GC-46	1.00 INSPECT VISUAL		.00115		.001	
0030 E					RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
		YH	01	21		1.00	RACE INSTALLATION WHL/HALF	.178	.037	.216	43
0010 E					RWB-BC-03	1.00 INSTALL BEARING CUPS		.16838		.203	
0020 E					RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
0290		YH	01	21		1.00	BALANCE WHEEL HALF	.111	.023	.134	27
0010 E					GPL-PD-01	4.00 REM NONTHEADED PLASTIC PLUG		.00339		.016	
0020 E					GMC-MT-D1	1.00 REMOVE MASKING TAPE		.00191		.002	
0030 E					RWB-OH-W2	1.00 REMV WHL HLF F/PAINT CONVOYOR		.00833		.010	
0040 E					RWB-BB-01	1.00 BALANCE WHEEL HALF		.07734		.093	
0050 E					RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
0295		YH	01	21		1.00	WHEEL MATCH UP	.110	.023	.134	27
0010 E					MST-EE-24	1.00 GET EASY AND PLACE EXACT		.00097		.001	
0020 E					RWB-UP-P7	1.00 UNPK PARTS-BK KEY-SNAP RING		.08237		.099	
0030 N						1.00	MATCH WHEEL HALFS 2 HALFS	.01700		.020	
0040 E					RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
9000		YH	01	21		.00	LABOR STANDARD HISTORY	.000	.000	.000	0

0010 06JUN84 SUB OP 0001 UNLOAD LINE<OLD STD> 1.85  
0020 26MAR85 2 YEAR REV NO CHNG (OLD TM 1.93)  
21 3MAR86 CHANGED SKILL CODE FROM Y6 TO YH  
0022 NO TIME CHANGE  
0023 20CT86 2 YEAR REVIEW, DELETED STEP 0140 SUBOP  
0024 0010 WORK DONE BY DS PERSONNEL <OLD STD 1.93>  
0900 KERRY COOP MANEL TECHN 73357

J INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

—X—X—>

.234567890123456 ELSE PUT IN END

BLDG 505/507

C-5B MAIN WHEEL  
BILL OF MATERIALS  
90101A

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ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART INIC	REV CODE	EFFECTIVITY DATE	TECH NUMBER	DRG ACTION	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
10		14974000-117C	11630011826267	198897	IC-38 MAIN WHEEL ASSY	1	EA										
1.1		1300-328-1	11630011084043	197153	WHEEL HALF ASSY (OUT-BOARD)	1	EA										
1.2		N.P.L.	N.S.L.		WHEEL HALF SUBASSY (OUTBOARD)	1											
1.3		N.P.L.	N.S.L.		...BUSHING & CUP ASSEMBLY (PSEUDO)	1	AR										
1.4		16303152	N.S.L.		...BUSHING (BEARING CUP) (REPAIR)	1											
1.5		1630310	13110002251916	160038	...CUP, (BEARING)	1	EA										
1.6		1630310	15340008140267	183324	...INSERT (ROZAM)	4	EA										
1.7		158258L	15340011578690	183324	...INSERT (ROZAM) (OVERSIZE)	4	AR:EA										
1.8		158258L	N.S.L.	197153	WHEEL HALF (OUTBOARD)	1											
1.9		110-1143-1	15310002752025	196906	...NUT (WEIGHT)	2	AR:EA										
1.10		197-74	11630000556302	197153	...WEIGHT (BALANCE) (10.50Z)	2	AR:EA										
1.11		197-53	11630008263028	197153	...WEIGHT (BALANCE) (10Z)	2	AR:EA										
1.12		19507C1032-20	N.S.L.		...SCREW (WEIGHT)	1	AR										
1.13		195244P958280	15305009586375	196906	...SCREW (WEIGHT)	1	AR:EA										
1.14		11630310	13110002251916	160038	...CUP (BEARING)	1	AR:EA										
1.15		138-105-18-13	N.S.L.	194222	...RIVET (PLATE)	16											
1.16		138-105-17-13	15340001757604	194222	...RIVET (PLATE)	16	EA										
1.17		138-105-16-13	N.S.L.	194222	...RIVET (PLATE)	16											
1.18		138-105-15-13	N.S.L.	194222	...RIVET (PLATE)	16											
1.19		150-242	N.S.L.		...PLATE (INSTRUCTION)	1											
1.20		150-243	19905004583116	197153	...PLATE (COUNTER)	1	EA										
1.21		150-282	N.S.L.		...PLATE (IDENTIFICATION)	1											
1.22		165-489	15345004876328	197153	...RING (RETAINING) (OUTER)	1	EA										
1.23		168-647	15330004563210	197153	...SEAL (GREASE) (OUTER)	1	EA										
1.24		1195-93	14820002533359	133525	...SAFETY VALVE ASSY (WITH PACKING)	1	EA										
1.25		1250142	15340004943024	133525	...SPRING (PUSHER)	1	EA										
1.26		15736-9969	N.S.L.	133525	...RING (RETAINING)	1											
1.27		1276375	N.S.L.	133525	...RETAINER (SPRING)	1											
1.28		1216461	N.S.L.	133525	...SPRING (POCKET)	1											
1.29		1276376	N.S.L.	133525	...POCKET	1											
1.30		1276373	N.S.L.	133525	...PISTON	1											
1.31		1216462	N.S.L.	133525	...SPRING (PISTON)	1											
1.32		1276372	N.S.L.	133525	...GUIDE (POCKET)	1											
1.33		16528775-012	15330005840265	196906	...PACKING (GUIDE)	1	EA										
1.34		16528775-018	15330006180799	196906	...PACKING (PISTON)	1	EA										
1.35		1276374	N.S.L.	133525	...HOUSING	1											
1.36		N.P.L.	N.S.L.		...HOUSING & PACKING ASSY (PSEUDO)	1	AR										
1.37		1260-812	11620011689325	194272	...HOUSING (OVERSIZE)	1	EA										
1.38		16528775-021	15330011607085	196906	...PACKING (HOUSING)	1	EA										
1.39		16516627-1118	15345007256283	196906	...RING (RETAINING) (SAFETY VALVE)	1	EA										
1.40		16528775-011	15330005822133	196906	...PACKING (SAFETY VALVE)	2	EA										
1.41		1300-329-1	11630011084044	197153	WHEEL HALF ASSY (IN-BOARD)	1	EA										
1.42		N.P.L.	N.S.L.		WHEEL HALF SUBASSY (INBOARD)	1											

5/2/11

16-May-80

BLD6 505/507

STL-STEEL  
AL-ALUMINUM  
MAG-MAGNESIUM  
TITA-TITANIUM  
SS-S STL  
SYN-SYNTHETIC  
LD-LEAD

C-3B MAIN WHEEL  
BILL OF MATERIALS

90101A

\* = MFI

ROUTED ITEMS	ILON LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD FACTOR	SCRAP TYPE (R,D,C)	PART MISC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH DRO NUMBER	PENDING 103 ACTION	PENDING 232 ACTION	PENDING AFTO 22 ACTION
	1.0.4	2391-30N0285	5340010979226	726344	.....INSERT (HELICOID, OUTER) (1ST REP)	1	EA									
	1.0.4	2391-30N0254	IN.S.L.		.....INSERT (HELICOID, INNER) (1ST REP)	1	EA									
	1.0.3	MS35914-108	5340010366016	96906	.....INSERT (ROZAM) (REPAIR)	19	AR EA				INT					
	1.0.3	110-1144-1	IN.S.L.		.....WHEEL HALF (INBOARD)	11										
	1.0.2	MS20364-1032C	5310002752025	96906	.....NUT (HEIGHT)	12	AR EA									
	1.0.2	197-74	1630000556302	97153	.....WEIGHT (BALANCE) (.050Z)	12	AR EA									
	1.0.2	167-33	16300008263028	97153	.....WEIGHT (BALANCE) (10Z)	12	AR EA				ALT					
	1.0.2	MS33207-268	53050009953442	96906	.....SCREEN (HEIGHT)	12	AR EA									
	1.0.2	16P60-10L	5310001670834	88044	.....WASHER (HEIGHT)	12	AR EA									
STL	1.0.2	1J236710A	5310002251917	60038	.....CLIP (BEARING)	11	AR EA									
	1.0.2	138-105-14-13	5320001757605	94222	.....RIVET (PLATE)	16	EA									
	1.0.2	150-242	IN.S.L.		.....PLATE (INSTRUCTION)	11										
	1.0.2	150-243	9905004583116	97153	.....PLATE (COUNTER)	11	EA									
	1.0.2	150-282	IN.S.L.		.....PLATE (IDENTIFICATION)	11										
SYN	1.0.2	168-893	5330001465371	97153	.....SEAL (GREASE) (INNER)	11	EA									
SS	1.0.2	1245-168	5330001275744	97153	.....RING (SEALING)	11	EA									
	1.1	1752-03	12640007267896	79934	.....VALVE ASSY	11	EA									
	1.0.2	1VCS	11650002224525	79934	.....CAP (VALVE)	11	EA									
	1.0.2	MS20813-1	11650002224525	96906	.....CAP (VALVE)	11	EA				INT					
	1.0.2	1CA	12640008105861	79934	.....VALVE	11	EA									
STL	1.0.2	1752	IN.S.L.	79934	.....STEM (VALVE)	11										
	1.0.2	18E30	53300005797548	73842	.....PACKING, O-RING (VALVE)	11	EA									
STL	1.1	MS27436-3	12640001166208	79934	.....VALVE ASSY (OVERSIZE)	11	AR EA				ALT					
	1.0.2	1VCS	11650002224525	79934	.....CAP (VALVE)	11	EA									
	1.0.2	MS20813-1	11650002224525	96906	.....CAP (VALVE)	11	EA				INT					
	1.0.2	1CA	12640008105861	79934	.....VALVE	11	EA									
	1.0.2	1752	IN.S.L.	79934	.....STEM (VALVE)	11										
	1.0.2	MS9048-011	5330000712204	96906	.....PACKING, O-RING (VALVE) (OVERSIZE)	11	EA									
	1.1	MS110253-8	IN.S.L.		.....SCREEN (DRIVE KEY)	19										
	1.1	MS110253-8	5305001579556	88044	.....SCREEN (DRIVE KEY)	19	EA				INT					
SS	1.1	1170-112	534000452910	97153	.....DRIVE KEY	19	EA									
	1.1	149-139	11630009871828	97153	.....PLUG ASSY	13	EA									
AL	1.0.2	149-138	IN.S.L.		.....PLUG (THERMAL RELIEF)	11										
	1.0.2	MS2875-006	5330002920580	60589	.....PACKING (THERMAL PLUG)	11	EA									
SS	1.1	172-283	1630012203847	97153	.....HEAT SHIELD	19	EA									
STL	1.1	1J4874377	5310004582846	72962	.....NUT (TIE)	18	EA									
STL	1.1	16N267	5310009045253	25500	.....NUT (TIE)	18	EA				INT					
STL	1.1	16N272-720	5310009481256	56878	.....NUT (TIE)	18	EA				INT					
STL	1.1	180-513	5310001344152	97153	.....WASHER (TIE)	132	EA									
STL	1.1	143-761	5305007958694	97153	.....BOLT (TIE)	18	EA									
	1.1	148-649	5330004537564	97153	.....PACKING (O-RING)	11	EA									
SYN	1.1	148-650	5330004533360	97153	.....GASKET	11	EA									

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FACTORED								
PROD NBR	RCL	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	STAND HOURS
90101A	MNPCE	H0010	N	M2	3	1.33	1.00	1.33
★								1.33
	MNPGP	00010	E	YH	5	.57	1.00	57
		PM101	E	YH	5	.13	1.00	13
		PP101	N	3S	5	.42	1.00	42
		PP103	E	3S	5	.33	1.00	33
		PP104	E	3S	5	.33	1.00	33
		PS103	E	YH	5	.42	1.00	42
		PS104	N	YH	5	.81	1.00	81
★								3.01
	MNPGW	WC001	N	KI	5	.60	1.00	60
		WD001	E	HB	5	.97	1.00	97
		WE103	N	DI	5	.51	1.00	51
		WE104	N	DI	5	.51	1.00	51
★								2.59
	MNPMG	XNPMG	X	JB	1	.25	1.00	25
★								25
	MNPNA	XNPNA	X	DB	2	.32	1.00	32
★								32
	MNPRA	RA103	E	JA	1	2.19	1.00	2.19
		RA104	N	JA	1	1.81	1.00	1.81
★								4.00
	MNPRC	RC103	E	UP	8	.94	1.00	94
		RC104	E	UP	8	.94	1.00	94
★								1.88
★								13.38

IN CONTROL JOP	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDER	6019 FLOW DAYS
NUMBER DESC						
DELE	74972A	B-52	BOOSTER ROTARY	1005-00-724-2862	28 OCTOBER 86	11W1-3-10-3
MART SHEL	74973A		DRIVE ASSY DRUM	1005-00-494-4583	101D4452	11W1-7-11-3 8
MART SHEL	74974A -6	F-4E	UNLOAD UNIT	1005-00-484-2745	175F981	11W1-7-11-3 6
MART SHEL	74975A -6	B-52	BOOSTER ASSY	1005-00-300-5135	102450-1	11F46-16-3 8
MART SHEL	74976A	A-7	DRIVE ASSY	1005-00-102-7987	175F705	
MART SHEL	74977A	F-4	CONTROL UNIT	1005-00-018-0825	A05A0089-4	1F-4E-2-18 8
MART SHEL	74978A -6	F-4C	FEEDER ASSY	1005-00-852-1898	175F449	11W1-31-2-2 12
MART SHEL	74979A	F-4	SWITCH CENTRIFUGE	1005-00-908-3828	822D80961	11W1-31-2-2 4
MART SHEL	74981A		FEEDER DELINKER	1005-00-921-6241	11701120	11W1-7-12-3 5
DELE	74983A -6		MINI GUN 5.56 MM	1005-00-973-5685	28 OCTOBER 86	11W3-5-5-1-1
MART SHEL	75175A -6		LAUNCHER LE-6	1440-00-483-5478AA	169605	11L1-3-14-3 20
DELE	75177G		LD-5	1440-00-673-7278AA	11 JULY 86	AFLCR 74-2
MART SHEL	75225A	F-111	EXIT UNIT SUU-16	1005-00-908-3825	721E72761	11W1-31-2-2 10
MART SHEL	75227A -6	F-111	DRIVE ASSY SUU-23	1005-00-908-3827	822D99661	11W1-31-2-2 10
MART SHEL	75228A	F-111	PANEL ASSY SUU-23	1005-00-836-5570	175F123	11W1-31-2-2 6
MART SHEL	75229A		GUN MOUNT PALLET ASSY	1005-00-054-3185	905D574	11W1-7-11-3 0
MART SHEL	75231A	F-4	SUU-20 B/A	1095-00-152-3360	69D6070	11B29-3-28-1 28
DELE	75232A		FEEDER M2A1	1005-00-473-6152	28 OCTOBER 86	11W1-7-9-2
DELE	75235A	F-111	EXIT UNIT	1005-00-111-4648	28 OCTOBER 86	11W1-29-6-2
MART SHEL	75236A -6	F-4	SUU20/A	1095-00-111-4657	SP245-1030	11B29-3-28-1 28
MART SHEL	75237A	F-4	SUU20	1095-00-984-1786	5712-503-1	11B29-3-28-1 28
MART SHEL	75247A		GUN M-39 A/2	1005-00-566-0044	8410950	11W1-12-3-14 20
MART SHEL	75254A -6		GUN M39/A3	1005-00-930-7787	8436501	11W1-12-3-22 20
MART SHEL	75265A	B-52	SWITCH ASSY	1005-00-733-1301	25-8598	11F8-3-0-2 8
MART SHEL	75267A -6		CYL GAS	1005-00-948-5311	11699885	11W1-12-7-2 7
MART SHEL	75269A	B-52	BOOSTER	1005-00-341-8559	199-2100-9	11W1-1-3-6-3 7
DELE	75272A		GAU-SA G	1005-00-933-7672	28 OCT 86	11W3-5-5-1
MART SHEL	75292A	B-52	BOOSTER	1005-00-604-0258	ABA400AB1	11W1-3-1-1 5
MART SHEL	75293A	F-4E	EXIT UNIT	1005-00-934-1432	175F138	11W1-7-11-3 2
CALD TOLM	77261A	B-52 ML6	CAM ASSY	1620-00-733-0993	25-4214	4S1-57-3 421
POLL POLL	78048A	C-141	DRAG BRACE	1620-00-943-8754	3F31004-119	4SA6-19-3 0
FRED FRED	79580A		PYRD TECHNIC PISTOL	1095-00-726-5657	7265657	11W2-9-2-31&34 8
MART SHEL	81466A	A-10	GAU-8 DRUM ASSY	1005-01-234-0764	218F504	11W1-7-14-3 20
COOP COOP	83317A	F-16	DRAG BRACE ASSY	1620-01-162-7542	2006500-111	4S2-00-13 30
MART SHEL	88425A	A-10	GAU-8 SCOOP DISC.	1005-01-234-0762	218F385	11W1-7-14-3 10
RIGB RIGB	89257A	F-4 M	PRESSURE PLATE	1630-00-498-3225	5000254	4B1-2-1093 16
JENS RIGB	89377A	F-16 M	BRAKE ASSY	1630-01-202-6584	50072714	4B1-2-1163 30
BENT PRIC	90101A	C-5B	WHEEL ASSY	1630-01-182-6267	3-1268-3	4W1-4-493 20
COOP TOLM	90400A	B52	LINK IN BOARD	1620-00-609-9886	25-4211	4S1-57-3 40
MART SHEL	94118A	A-10	GAU-8 DRUM ASSY	1005-01-234-0763	218F966	11W1-7-14-3 29
RIGB RIGB	97414A	F-16 M	HEAT STACK	1630-01-252-4702	8631424-30	4B1-2-1163 20
RIGB RIGB	99020A	F-16 M	HEAT STACK	1630-01-252-4703	8631424-10	4B1-2-1163 20



# C-5 MAIN WHEEL

WHEEL ASSY  
PCN 90101A  
WCD 21101N

WHEEL HALF  
INBOARD  
PCN 90101A  
WCD 21103N

WHEEL HALF  
OUTBOARD  
PCN 90101A  
WCD 21104N

\* C-5 A MAIN WHEEL \*

WCD# 21101N  
Assy/DisAssy

OP# IN  
INDUCT

OP# 01B  
LOAD

OP# 02C  
DisAssy  
HALVES

WCD# 21104N  
OUTER

WCD# 21103N  
INNER

OP# 006  
REMOVE CUP FROM  
WHEEL HALF

OP# 006  
REMOVE CUP FROM  
WHEEL HALF

OP# 006A  
LINE TRANSFER  
CONV. → CRANE

OP# 006A  
LINE TRANSFER  
CONV. → CRANE

OP# 007  
CHEM. CLEAN

OP# 007  
CHEM. CLEAN

OP# 007  
BLAST CLEAN

OP# 011  
ANODIZE STRIP

OP# 015 & 015A  
F.P.I.

OP# 19  
NICK & BURR

OP# 030  
E & I & ROUTE

OP# 040  
THREADED INSERT  
REPAIR

OP# 043  
REMOVE BROKEN  
SCREWS

OP# 045  
SAFETY VALVE HOLE  
REPAIR

OP# 048  
VALVE STEM HOLE  
REPAIR

OP# 008  
BLAST CLEAN

OP# 009  
REMOVE BROKEN  
SCREWS

OP# 010  
E.D.M. BROKEN TAPS  
& SCREWS

OP# 011  
ANODIZE STRIP

OP# 015 & 015A  
F.P.I.

OP# 019  
NICK & BURR

OP# 030  
E & I & ROUTE

OP# 044  
POLISH OR MACHINE  
BASE OF DRIVE  
KEY BOSS

OP# 045  
REMOVE HELICOLS

OP# 055  
BEARING BORE  
REPAIR

OP# 058  
BEARING BORE SEAT  
REPAIR

OP# 060  
SHOT PEEN

OP# 70A, 70B, 70C, 70D  
70E, 70F, 70G, 70H,  
70I, 70J, 70K, 70L } ANODIZE

OP# 072  
INSTALL CUP INTO  
BEARING BORE

OP# 074  
MACHINE O.D. OF CUP  
& BUSHING ASSY

OP# 076  
INSTALL CUP & BUSHING  
INTO BEARING BORE

OP# 077  
INSTALL CUP INTO BEARING  
BORE & SEAL BUSHING

OP# 056  
BEARING BORE  
REPAIR

OP# 056  
BEARING BORE REPAIR

OP# 057  
BEARING BORE SEAT  
REPAIR

OP# 59  
BEARING & SEAL  
GROOVE REPAIR

OP# 060  
SHOT PEEN

ANODIZE { OP# 70A, 70B, 70C, 70D,  
70E, 70F, 70G, 70H,  
70I, 70J, 70K, 70L

OP# 073  
INSTALL CUP INTO  
BEARING BORE

OP# 074  
MACHINE O.D. OF  
BUSHING & CUP ASSY

OP# 078  
MACHINE O.D. OF CUP  
& BUSHING ASSY

OP# 075  
INSTALL CUP &  
BUSHING ASSY

OP# 079  
INSTALL BUSHING & CUP  
ASSY INTO BEARING  
BORE

OP# 077  
INSTALL CUP INTO  
BEARING BORE & SEAL  
BUSHING

OP# 080  
INSTALL INSERTS

OP# 078  
MACHINE O.D. OF  
CUP & BUSHING ASSY

OP# 095  
MOVE TO PRE-FINAL  
INSP & ASSY &  
LOAD ROLLER CONV.

OP# 079  
INSTALL CUP &  
BUSHING ASSY

OP# 098  
RAKE INSTALLATION

OP# 080  
INSTALL HELICOLS

OP# 098A  
UNLOAD ROLLER CONV.

OP# 095  
MOVE TO PRE-FINAL  
INSP & ASSY &  
LOAD ROLLER CONV.

OP# 100  
LOAD OVERHEAD CONV.

OP# 098  
RAKE INSTALLATION

OP# 100A  
WASH

OP# 098A  
UNLOAD ROLLER CONV.

OP# 100B  
MASK

OP# 100C  
PRIME

OP# 100  
LOAD CEMENT CON.

OP# 100D  
DRY

OP# 100A  
WASH

OP# 100E  
1ST PAINT

OP# 100B  
MASK

OP# 100F  
2ND PAINT

OP# 100C  
PRIME

OP# 100G  
DRY

OP# 100D  
DRY

OP# 100H  
STRIP

OP# 100E  
1ST PAINT

OP# 100I  
UNLOAD OVERHEAD  
CONV.

OP# 100F  
2ND PAINT

OP# 110  
INSTALL SAFETY  
VALVE

OP# 100G  
DRY

OP# 120  
TEST SAFETY  
VALVE

OP# 100H  
STRIP

OP# 100I  
UNLOAD OVERHEAD  
CONV.

OP# 122  
BALANCE

OP# 122  
BALANCE

OP# 130  
INSTALL SEALS  
& RETAINERS  
FINAL INSP.

OP# 130  
INSTALL SEALS  
& RETAINERS  
FINAL INSP

WCD# 21101N  
ASSY/DISASSY

OP# 10  
MATCH-UP

OP# 20  
ASSY WHEEL HALVES

OP# 30  
TOUCH-UP PAINT

OP# 40  
FINAL ACCEPT.

OP# 50  
FINAL PROD. VISUAL

OP# 9999  
SELL

## 21101N WORK CONTROL DOCUMENT (MEDS)

1 DATE 00354

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC MNP GW	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA 4W-1-61 4W1-4-493	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES C-5 MAIN	11 STOCK NUMBER	12 OPTIONAL 90101A 72899A
13 SERIAL NUMBER	14 NOUN WHEEL ASSEMBLY	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 4G94000-117C 3-1268-2		NSN C/N 1630011826267 90101A 1630001884084 72899A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLIC- ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		"WARNING" MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001 *REQD*	3-1268-3 4G94000-117C			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21101N
		B	D	171



## 21101N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88354

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2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN WHEEL ASSEMBLY	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
13	010 *REQD*	*MATCH-UP* ROUTED COMPONENTS NEW/SERVICEABLE REWORK NO REWORK		001 MNFGP 002 07 003 MU02	
		WHEEL HALF SUBASSY (I.B.) 21103N WHEEL HALF SUBASSY (O.B.) 21104N			
13	020 *REQD*	ASSEMBLE *C/P MOVE*		001 MNFGP 002 07 003 WA03	
13	030 *REQD*	FINAL TOUCH-UP PAINT *C/P MOVE*		001 MNFGP 002 09 003 TU04	
13	040 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNFGP 002 09 003 TU04	
13	050 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE*		001 MNFGP 002 09 003 TU04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SH
DISPATCH	FUNCTIONAL CODE	A	C	21101N
		B	D	

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC MNPGR	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA 4W-1-61 4M1-4-493	9 ITEM SERIAL NO
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10 MODEL-DESIGN-SERIES C-5 MAIN	11 STOCK NUMBER	12 OPTIONAL 72899A 90101A
13 SERIAL NUMBER	14 NOUN WHEEL HALF - INNER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
300-329-1		1630011084044 72899A			
300-329-1		1630011084044 90101A			
		***** UNIT COST: \$1953.91 *****			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		FPI IAW MIL-STD-6866			
		SHOT PEEN IAW MIL-S-13165			
		ANODIZE IAW MIL-A-8625			
		*****2014-T6 ALUMINUM*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. (CONTINUED)			

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/SN
DISPATCH	A	21103N
FUNCTIONAL CODE	C	
	D	

21103N

## WORK CONTROL DOCUMENT (MEDS)

1 DATE 88237

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PAGE OF PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER		8 TECH DATA		9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL HALF - INNER	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	300-329-1			
✓ 34D	005 *REQD*	DISASSEMBLE *C/P MOVE*		001 MNFGW 002 02 003 WD03	
34D	006 *REQD*	REMOVE COP FROM WHEEL HALF *C/P MOVE*		001 MNFGW 002 02 003 WD03	
✓ 34C	007 *REQD*	CHEM CLEAN *C/P MOVE*		001 MNFGW 002 03 003 AC02	
✓ 34B	008 *REQD*	BLAST CLEAN *C/P MOVE		001 MNFGW 002 03 003 BL01	
✓ 69	009 1.0	REMOVE BROKEN SCREWS *C/P MOVE		001 MNFGW 002 01 003 BE01	
38	010 .04	EDM BROKEN SCREWS & TAPS *C/P MOVE*		001 MNFGW 002 02 003 ME10	
✓ 34C	011 *REQD*	ANODIZE STRIP *C/P MOVE*		001 MNFGW 002 03 003 AN03	
		*REQD*	M	001 MNFGW 002 05 003 ZY05	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21103N
		B	D	

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1 DATE 88237

3 PAGE 3 OF 3 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL HALF - INNER	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34E	019 *REQD*	NICK AND BURR *C/P MOVE*		001 MNFGW 002 04 003 NB04	
34E	030 *REQD*	E & I AND ROUTE *C/P MOVE*		001 MNFGW 002 04 003 EI02	
69	044 .34	LOCAL POLISH OR MACH AT BASE OF DRIVE KEY BOSS IAW PAR 5.1.1 K.A. .060 DEEP BY 2.5 INCHES MAX 63 RMS FINISH *C/P MOVE*		001 MNFGW 002 01 003 BE01	
69	045 *REQD*	REMOVE HELICOILS *C/P MOVE*		001 MNFGW 002 01 003 BE01	
69	050 .02	RETAINER GROOVE REPAIR IAW PAGE 1-7 PARA J (2) *C/P MOVE*		001 MNFGW 002 01 003 MV04	
69	056 .01	BEARING BORE REPAIR (INBOARD) IAW FIG 5-5 *C/P MOVE*		001 MNFGW 002 01 003 MV04	
69	057 .01	BEARING BORE SEAT REPAIR (INBOARD) *C/P MOVE*		001 MNFGW 002 01 003 MV04	
69	059 .01	BEARING AND SEAL GROOVE REPAIR IAW FIG 5-6 & 5-7 *C/P MOVE*		001 MNFGW 002 01 003 MV04	
26	060 *REQD*	SHOT PEEN MIL-S-13165 INTENSITY OF .08 TO .012 A2 SHOT SIZE CCW 28 WITH 200% COVERAGE *C/P MOVE*		001 MNFGW 002 01 003 SP01	
26	070 *REQD*	ANODIZE TYPE II CLASS I *C/P MOVE*		001 MNFGW 002 03 003 AS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21103N
		B	D	

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN WHEEL HALF - INNER	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
✓ 69	073 .02	INSTALL CUP INTO BEARING BORE BUSHING (1ST REPAIR) P/N LM236710A P/N 63B31152 C/P MOVE			
✓ 69	074 .01	MACHINE O.D. OF BUSHING AND CUP ASSEMBLY (1ST) REPAIR C/P MOVE			
✓ 69	075 .01	INSTALL CUP AND BUSHING ASSEMBLY INTO BEARING BORE (1ST REPAIR) *C/P MOVE* P/N N.P.L.		001 MNFRA 002 01 003 BE01	
✓ 69	077 .01	INSTALL CUP INTO BEARING BORE AND SEAL BUSHING (2ND REPAIR)*C/P MOVE* P/N LM236710A P/N 66C330D1-121		001 MNFRA 002 01 003 BE01	
✓ 69	078 .01	MACHINE O.D. OF BUSHING AND CUP ASSY (2ND REPAIR) *C/P MOVE*		001 MNFRA 002 01 003 LE09	
✓ 69	079 .01	INSTALL CUP AND BUSHING ASSEMBLY INTO BEARING BORE (2ND REPAIR) *C/P MOVE* P/N N.P.L.		001 MNFRA 002 01 003 BE01	
✓ 69	080 *REQD*	INSTALL HELICOILS 100% REQUIREMENT *C/P MOVE*		001 MNFRA 002 01 003 BE01	
✓ 13	095 *REQD*	PRE-FINAL INSPECTION AND ASSEMBLE *C/P MOVE*		001 MNFRA 002 07 003 PF05	
✓ 13	098 1.0	RACE INSTALLATION *C/P MOVE* P/N LM236710A		001 MNFRA 002 07 003 RI06	
✓ 13	100 *REQD*	PAINT *C/P MOVE*		001 MNFRA 002 09 003 BS02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21103N
		B	D	



## 21104N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88237

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC MNPOM		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA 4W-1-61 4M1-A-493				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES C-5 MAIN				11 STOCK NUMBER				12 OPTIONAL 90101A 72899A	
13 SERIAL NUMBER		14 NOUN WHEEL HALF - OUTER							
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
P/N		NSN C/N							
300-328-1		1630011084043 90101A							
300-328-1		1630011084043 72899A							
		***** UNIT COST: \$672 *****							
		GOVERNING DIRECTIVES: AFLCR 66-51							
		MANDI 66-3							
		FPI IAW MIL-STD-6866							
		SHOT PEEN IAW MIL-S-13165							
		ANODIZE IAW MIL-A-8625							
		*****2014-T6 ALUMINUM*****							
		ALL PERSONNEL INVOLVED IN THE WORK							
		PROCESSES SPECIFIED IN THIS DOCUMENT							
		HAVE BEEN THOROUGHLY TRAINED AND ARE							
		FAMILIAR WITH ALL PERTINENT SAFETY							
		PRACTICES AND HAZARDS CONTAINED IN							
		THE BASIC TECHNICAL ORDER (T.O.) AND							
		T.O. SUPPLEMENTS REFERENCED. THE							
		APPLICABLE T.O.'S AND SUPPLEMENTS							
		WILL ALWAYS BE USED IN CONJUNCTION							
		WITH THIS DOCUMENT.							
		*COMPONENTS WILL BE THOROUGHLY							
		CLEANED & PROTECTED (C/P MOVE) FOR							
		MOVES BETWEEN OPERATIONS/DISPATCH							
		STATIONS.							
		WARNING							
		MANY OF THE FOLLOWING REPAIR							
		PROCEDURES REQUIRE THE USE OF							
		EQUIPMENT, PROCESSES & CHEMICALS							
		WHICH ARE POTENTIALLY DANGEROUS TO							
		PERSONNEL. ADEQUATE SAFEGUARDS AND							
		PRECAUTIONS MUST BE EMPLOYED TO							
		PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN							
		COLUMN 16 IS EQUIVALENT TO DELTA							
		STAMP.							
	001	300-328-1							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21104N			
		B		D					

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1 DATE 20237

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL HALF - OUTER	

15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
34D	005 *REQD*	DISASSEMBLE *C/P MOVE*		001 MNFGW 002 02 003 WD03	
34D	006 *REQD*	REMOVE COP FROM WHEEL HALF *C/P MOVE*		001 MNFGW 002 02 003 WD03	
34C	007 *REQD*	CHEM CLEAN *C/P MOVE*		001 MNFGW 002 03 003 AC02	
34B	009 *REQD*	BLAST CLEAN ONLY *C/P MOVE*		001 MNFGW 002 03 003 BL01	
34C	011 *REQD*	ANDUZE STRIP *C/P MOVE*		001 MNFGW 002 03 003 AN03	
		*C/P MOVE*	M	001 MNFNA 002 05 003 ZY05	
34E	019 *REQD*	NICK AND BURR *C/P MOVE*		001 MNFGW 002 04 003 NB04	
34E	030 *REQD*	E & I AND ROUTE *C/P MOVE*		001 MNFGW 002 04 003 EI02	
69	040 *REQD*	THREADED INSERT REPAIR (41) IAW PG 1-6 PARA 5-1.1(1) THRU (5) *C/P MOVE*		001 MNFRA 002 01 003 BE01	
69	043 .01	REMOVE BROKEN SCREWS *C/P MOVE*		001 MNFRA 002 01 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21104N
		B	D	



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## WORK CONTROL DOCUMENT (MEDS)

1 DATE 88237

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF - OUTER						
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
69	045 .50	SAFETY VALVE HOLE REPAIR IAW FIG 5-4 *C/P MOVE*					001 MNFRA 002 01 003 MV04		
69	048 .01	VALVE STEM HOLE REPAIR IAW MS33649-03 *C/P MOVE*					001 MNFRA 002 01 003 DR02		
69	055 .02	BEARING BORE REPAIR (OUTBOARD) IAW FIG 5-5, 5-6, 5-7 *C/P MOVE*					001 MNFRA 002 01 003 LE09		
69	058 .01	BEARING BORE SEAT REPAIR (OUTBOARD) *C/P MOVE*					001 MNFRA 002 01 003 LE09		
26	060 *REQD*	SHOT PEEN MIL-S-13165 INTENSITY OF .08 TO .012 A2 SHOT SIZE CCW 28 WITH 200% COVERAGE *C/P MOVE*					001 MNFRC 002 01 003 SP01		
26	070 *REQD*	ANDDIZE TYPE II *C/P MOVE*					001 MNFRC 002 03 003 AS03		
69	072 .03	INSTALL CUP INTO BEARING BORE BUSHING (1ST REPAIR) P/N L6630310 P/N 63B31152 *C/P MOVE*							
69	074 .02	MACHINE O.D. OF BUSHING AND CUP ASSY (1ST REPAIR) P/N N.P.L. *C/P MOVE*					001 MNFRA 002 01 003 LE09		
69	076 .02	INSTALL BUSH AND CUP ASSY INTO BEARING BORE (1ST REPAIR)*C/P MOVE* P/N N.P.L.					001 MNFRA 002 01 003 BE01		
69	077 .01	INSTALL CUP INTO BEARING BORE AND SEAL BUSHING (2ND REPAIR)*C/P MOVE* P/N L6630310 (CONTINUED)					001 MNFRA 002 01 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21104N			
		B		D					

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## 21104N WORK CONTROL DOCUMENT (MEDS)

1 DATE 08287

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2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN WHEEL HALF - OUTER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		P/N 66C33001-119			
✓ 69	078 .01	MACHINE O.D. OF BUSHING AND CUP ASSY (2ND REPAIR) *C/P MOVE* P/N N.P.L.		001 MNFRA 002 01 003 LE09	
✓ 69	079 .02	INSTALL BUSHING AND CUP ASSEMBLY INTO BEARING BORE (2ND REPAIR) *C/P MOVE* P/N N.P.L.		001 MNFRA 002 01 003 BE01	
✓ 69	080 *REQD*	INSTALL INSERTS IAW PAGE 6-1 PARA 5-1.1 (1) THRU (5) *C/P MOVE*		001 MNFRA 002 01 003 BE01	
✓ 13	095 *REQD*	PRE-FINAL INSPECTION AND ASSEMBLE *C/P MOVE*		001 MNFRA 002 07 003 PF05	
✓ 13	098 .99	RACE INSTALLATION *C/P MOVE* P/N L663010		001 MNFRA 002 07 003 RI06	
✓ 13	100 *REQD*	PAINT *C/P MOVE*		001 MNFRA 002 09 003 BS02	
✓ 13	110 *REQD*	INSTALL SAFETY VALVE *C/P MOVE* P/N 195-93		001 MNFRA 002 07 003 WE01	
✓ 13	120 *REQD*	TEST SAFETY VALVE HOLE AT 90-100 PSI *C/P MOVE*		001 MNFRA 002 07 003 WE01	
✓ 13	122 *REQD*	BALANCE *C/P MOVE*		001 MNFRA 002 07 003 WE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21104N
		B	D	

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF - OUTER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
13	123 *REQD*	INSTALL SEALS & RETAINERS *C/P MOVE*					001 MNP GP		
							002 07		
							003 WA03		
13	125 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNP GP		
							002 07		
							003 WA03		
13	130 *REQD*	FINAL PRODUCTION VISUAL INSPECTION *C/P MOVE*					001 MNP GP		
							002 07		
							003 WA03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21104N			
		B		D					

## 21121N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88222

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2 JOB ORDER NO 90101A	3 QUANTITY <i>1ea</i>	4 PRODUCTION SEC RCC MPCGW	5 DATE SCHED	6 DATE COMPLETED 15 APR 88
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7 PART NUMBER 3-1268-3	8 TECH DATA 4W-1-61 4W1-4-493	9 ITEM SERIAL NO 4276/5478
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10 MODEL DESIGN SERIES C-5B MAIN	11 STOCK NUMBER 1630211826267	12 OPTION <b>PAC</b>
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13 SERIAL NUMBER	14 NAME WHEEL ASSEMBLY
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15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "O"
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GOVERNING DIRECTIVES: AFLOR 66-61  
MANCI 66-3  
ALL PERSONNEL INVOLVED IN THE WORK  
PROCESSES SPECIFIED IN THIS DOCUMENT  
HAVE BEEN THOROUGHLY TRAINED AND ARE  
FAMILIAR WITH ALL PERTINENT SAFETY  
PRACTICES AND HAZARDS CONTAINED IN  
THE BASIC TECHNICAL ORDER AND T.O.  
SUPPLEMENTS REFERENCED IN BLOCK 8  
OF THIS AFLC FORM 958. THE APPLIC-  
ABLE T.O.'S AND SUPPLEMENTS WILL  
ALWAYS BE USED IN CONJUNCTION WITH  
THIS DOCUMENT.

\*COMPONENTS WILL BE THOROUGHLY  
CLEANED AND PROTECTED (C/P MOVE) FOR  
MOVES BETWEEN OPERATIONS/DISPATCH  
STATIONS.

WARNING  
MANY OF THE FOLLOWING REPAIR  
PROCEDURES REQUIRE THE USE OF  
EQUIPMENT, PROCESSES, & CHEMICALS  
WHICH ARE POTENTIALLY DANGEROUS TO  
PERSONNEL. ADEQUATE SAFEGUARDS AND  
PRECAUTIONS MUST BE EMPLOYED TO  
PRECLUDE INJURIES.

\*REQD\* (MANDATORY REQUIREMENT) IN  
COLUMN 16 IS EQUIVALENT TO DELTA  
STAMP.

13	020 *REQD*	REASSEMBLE WHEEL HALVES *C/P MOVE			
13	230 *REQD*	FINAL TOUCH-UP PAINT *C/P MOVE			

21 FINAL DESTINATION DISPATCH	22 COORDINATION/INITIATING RCC SIGNATURE/DATE A <i>Frank H. Rigby</i> C <i>James H. Murray</i> B <i>Steve MARISMB</i> D <i>Edward J. Cundick</i>	23 DOCUMENT/SN 21121N
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## 21101N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88222

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCT/ON SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL ASSEMBLY						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 DATE	20 TIME	
13	040 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958				18 10/10/88	19 10/10/88		
13	250 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE				18 10/10/88	19 10/10/88		
		COORDINATED BY: PLANNING: FRANK RIGBY WK MEASURE: FRANK RIGBY SCHEDULING: SUE WARD							
		PRODUCTION: ROGER MURRAY							
		QUALITY: ED OVERDIER							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21101N			
		B		D					

MANPROTECT

21104N WORK CONTROL DOCUMENT (MEDS)

DATE 88237

PAGE 1 OF 1

2 JOB ORDER NO 90101A	3 QUANTITY 1	4 PRODUCTION SEC RCC MNP GW	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER 300-328-1	8 TECH DATA 4W-1 4W1-4-493	9 ITEM SERIAL 4276
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10 MODEL DESIGN SERIES C 5B MAIN	11 STOCK NUMBER 1630011084043	12 OPTIONAL
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13 SERIAL NUMBER E29266	14 NOUN WHEEL HALF - OUTER
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15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 P	20 Q
		***** UNIT COST: \$672 ***** GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3 FPI IAW MIL-STD-6866 SHOT PEEN IAW MIL-S-13165 ANODIZE IAW MIL-A-8625 *****2014-T6 ALUMINUM*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	300-328-1			

21 FINAL DESTINATION DISPATCH	22 COORDINATION/INITIATING RCC SIGNATURE/DATE A. Thomas G. [Signature] MANEL 31 Aug 88 [Signature] MAN SM 31 AUG 88	23 DOCUMENTATION 80 AUG 1988 [Signature] 30 Aug 88 [Signature] MANEL
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## 21104N WORK CONTROL DOCUMENT (MEDS)

DATE 88237

PAGE 2

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SIGNATURE		5 DATE SCHED		6 DATE COMPLETE	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN WHEEL HALF - OUTER					
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P		
34D	005	DISASSEMBLE *C/P MOVE*					M		
	*REQD*								
34D	006	REMOVE CUP FROM WHEEL HALF *C/P MOVE*					M		
	*REQD*								
34C	007	CHEM CLEAN *C/P MOVE*					M		
	*REQD*	20 MAR 1989							
34B	009	BLAST CLEAN ONLY *C/P MOVE*					M		
	*REQD*	22 MAR 1989							
34C	011	ANODIZE STRIP *C/P MOVE*					M		
	*REQD*	22 MAR 1989							
34Z	015	FPI *C/P MOVE*					M		
	*REQD*								
34E	019	NICK AND BURR *C/P MOVE*					M		
	*REQD*								
34E	030	E & I AND ROUTE *C/P MOVE*					23 MAR 1989		
	*REQD*								
69	040	THREADED INSERT REPAIR (41) IAW PG 1-6 PARA 5-1.1(1) THRU (5) *C/P MOVE*					MAR 23 1989		
	*REQD*								
69	043	REMOVE BROKEN SCREWS *C/P MOVE*							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						21104N			

## 21104N WORK CONTROL DOCUMENT (MEDS)

DATE 98237

PAGE 3 OF 3

2 JOB ORDER NO.		3 QUANTITY		4 PROJECT OR IN SERVICE		5 DATE SCHEDULED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA			9 ITEM SERIAL NO.			
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF - OUTER						
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20	
69	045	SAFETY VALVE HOLE REPAIR IAW FIG 5-4 *C/P MOVE*					M		
69	048	VALVE STEM HOLE REPAIR IAW MS33649-03 *C/P MOVE*					M		
69	055	BEARING BORE REPAIR (OUTBOARD) IAW FIG 5-5, 5-6, 5-7 *C/P MOVE*							
69	058	BEARING BORE SEAT REPAIR (OUTBOARD) *C/P MOVE*							
26	060	SHOT PEEN MIL-S-13165 INTENSITY OF .08 TO .012 A2 SHOT SIZE CCW 28 WITH *REQD* 200% COVERAGE *C/P MOVE*				MAR 23 1989 70944			
26	070	ANODIZE TYPE II *REQD* *C/P MOVE*				MAR 23 1989 70944			
69	072	INSTALL CUP INTO BEARING BORE BUSHING (1ST REPAIR) P/N L6630310 P/N 63B31152 *C/P MOVE*					M		
69	074	MACHINE O.D. OF BUSHING AND CUP ASSY (1ST REPAIR) P/N N.P.L. *C/P MOVE*					M		
69	076	INSTALL BUSH AND CUP ASSY INTO BEARING BORE (1ST REPAIR)*C/P MOVE* P/N N.P.L.							
69	077	INSTALL CUP INTO BEARING BORE AND SEAL BUSHING (2ND REPAIR)*C/P MOVE* P/N L6630310 (CONTINUED)					M		
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT NO.			
DISPATCH	FUNCTIONAL CODE	A		C		21104N			
		B		D					



## 21104N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88237

PAGE 4

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC		5 DATE SCHED		6 DATE SHIPPED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL	
10 MODEL DESIGN SERIES		11 STOCK NUMBER				12 OPTIONAL			
13 SERIAL NUMBER		14 NOUN WHEEL HALF - OUTER							
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20	
		P/N 66C33001-119							
69	078	MACHINE O.D. OF BUSHING AND CUP ASSY (2ND REPAIR) *C/P MOVE* P/N N.P.L.					M		
69	079	INSTALL BUSHING AND CUP ASSEMBLY INTO BEARING BORE (2ND REPAIR) *C/P MOVE* P/N N.P.L.					M		
69	080	INSTALL INSERTS IAW PAGE 6-1 PARA 5-1.1 (1) THRU (5) *C/P MOVE*				70207	70207		
13	095	PRE-FINAL INSPECTION AND ASSEMBLE *C/P MOVE* 10 3 APR 1989				APR 0 3 1989	71057		
13	098	RACE INSTALLATION P/N L663010 *C/P MOVE* 10 3 APR 1989				71057	71057		
13	100	PAINT *C/P MOVE* *REQD* 4 APR 1989				70725	70725		
13	110	INSTALL SAFETY VALVE *C/P MOVE* P/N 195-93 APR 0 4 1989				70725	70725		
13	120	TEST SAFETY VALVE HOLE AT 90-100 PSI *C/P MOVE* APR 0 4 1989							
13	122	BALANCE *C/P MOVE* *REQD* 10 3 APR 1989							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						21104N			

5 5  
PAGE OF 10

[illegible]

PREVIOUS EDITION WILL BE USED

2 JOB ORDER NO 90101A	3 QUANTITY 92A1 EA	4 PRODUCTION SEC-RCC MNPGR	5 DATE SCHED MAR 28 1988	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA 4W-1-51 4W1-4-493	9 ITEM SERIAL NO 5472
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10 MODEL-DESIGN-SERIES C 5B MAIN	11 STOCK NUMBER	12 OPTIONAL
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13 SERIAL NUMBER E30218	14 NOUN WHEEL HALF - INNER
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15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19	20
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P/N	NSN	C/N			
300-329-1	1630011084044	25323A			
300-329-1	1630011084044	90101A			

***** UNIT COST: \$1953.91 *****					
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GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3					
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FPI IAW MIL-STD-6866					
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SHOT PEEN IAW MIL-S-13165					
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ANODIZE IAW MIL-A-8625					
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*****2014-T6 ALUMINUM*****					
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ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE					
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FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED; THE					
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APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.					
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*COMPONENTS WILL BE THOROUGHLY					
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CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.					
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WARNING					
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MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO					
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PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.					
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*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.					
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1 FINAL DESTINATION	22 COORDINATION/INITIATING RCC SIGNATURE/DATE	23 DOCUMENT/SN
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DISPATCH	FUNCTIONAL CODE	31 AUG 88 MANEL 31 AUG 88 MANSM 31 AUG 88	30 AUG 1993 30 AUG 88 MANEL	21103N
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21103N

## WORK CONTROL DOCUMENT (MEDS)

1 DATE 38237

2  
PAGE OF PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN WHEEL HALF - INNER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	001	300-329-1			
34D	005 *REQD*	DISASSEMBLE *C/P MOVE* MAR 28 1989	70288	70288	
34D	006 *REQD*	REMOVE CUP FROM WHEEL HALF *C/P MOVE* MAR 28 1989	70288	70288	
34C	007 *REQD*	CHEM CLEAN *C/P MOVE* MAR 28 1989	70288	70288	
34B	008 *REQD*	BLAST CLEAN *C/P MOVE*	70288	70288	
69	009	REMOVE BROKEN SCREWS *C/P MOVE*			
68	010	EDM BROKEN SCREWS & TAPS *C/P MOVE*			
34C	011 *REQD*	ANODIZE STRIP *C/P MOVE*	71399		
34Z	015 *REQD*	FPI *C/P MOVE*			
34E	019 *REQD*	WICK AND BURR *C/P MOVE*	71030		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21103N
		B	D	

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED		
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL DESIGN SERIES			11. STOCK NUMBER			12. OPTIONAL				
13. SERIAL NUMBER			14. NOUN WHEEL HALF - INNER							
15. DISPATCH STATION		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED			18. MECHANIC		19. "P"	
34E		030 *REQD*		E & I AND ROUTE *C/P MOVE*			M			
69		044		LOCAL POLISH OR MACH AT BASE OF DRIVE KEY BOSS IAW PAR 5.1.1 K.A. .060 DEEP BY 2.5 INCHES MAX 63 RMS FINISH *C/P MOVE*			M			
69		045 *REQD*		REMOVE HELICOILS *C/P MOVE*			M			
69		050		RETAINER GROOVE REPAIR IAW PAGE 1-7 PARA J (2) *C/P MOVE*			M			
69		056		BEARING BORE REPAIR (INBOARD) IAW FIG 5-5 *C/P MOVE*			M			
69		057		BEARING BORE SEAT REPAIR (INBOARD) *C/P MOVE*			M			
69		059		BEARING AND SEAL GROOVE REPAIR IAW FIG 5-6 & 5-7 *C/P MOVE*			M			
26		060 *REQD*		SHOT PEEN MIL-S-13165 INTENSITY OF .08 TO .012 A2 SHOT SIZE CCW 28 WITH 200% COVERAGE *C/P MOVE*			M			
26		070 *REQD*		ANODIZE TYPE II CLASS 1 *C/P MOVE*			M			
69		075		INSTALL COP INTO BEARING BORE BUSHING (1ST REPAIR) P/N LM236710A (CONTINUED)			M			
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH		FUNCTIONAL CODE		A		C		21103N		
				B		D				

2. JCB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN WHEEL HALF - INNER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		P/N 63B31152 C/P MOVE							
69	074	MACHINE O.D OF BUSHING AND CUP ASSEMBLY (1ST) REPAIR C/P MOVE							
69	075	INSTALL CUP AND BUSHING ASSEMBLY INTO BEARING BORE (1ST REPAIR) *C/P MOVE* P/N N.P.L.					M		
69	077	INSTALL CUP INTO BEARING BORE AND SEAL BUSHING (2ND REPAIR)*C/P MOVE* P/N LM236710A P/N 66C330D1-121					M		
9	078	MACHINE O.D. OF BUSHING AND CUP ASSY (2ND REPAIR) *C/P MOVE*					M		
69	079	INSTALL CUP AND BUSHING ASSEMBLY INTO BEARING BORE (2ND REPAIR). *C/P MOVE* P/N N.P.L.					M		
69	080 *REQD*	INSTALL HELICOILS 100% REQUIREMENT *C/P MOVE*				70207	70207		
13	095 *REQD*	PRE-FINAL INSPECTION AND ASSEMBLY *C/P MOVE* 10 4 APR 1989				70207	70207		
13	096 WCO 100	RACE INSTALLATION *C/P MOVE* P/N LM236710A 10 4 APR 1989				7080	7080		
13	100 *REQD*	PAINT *C/P MOVE* 10 4 APR 1989				7072	7072		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				21103N			
		B							
		C							
		D							

21103N

## WORK CONTROL DOCUMENT (MEDS)

1 DATE 38237

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PAGE OF PAGES

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN WHEEL HALF - INNER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
15	122 *REQD*	BALANCE APR 04 1965 *C/P MOVE*				10V01 71019	10V01 71019		
13	123 *REQD*	INSTALL SEALS AND RETAINERS APR 04 1965 *C/P MOVE*							
13	125 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS 4115 958 APR 04 1965					10V01 71152		
13	130 *REQD*	FINAL PRODUCTION VISUAL INSPECTION *C/P MOVE* APR 04 1965					10V01 71152		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						21103N			

90101A C-5 M WHL ASSY.

RCC NRCP

401-40-497

STORE

DEER TECH S B W P FT AYR REV

SLB T A R A FA EFFORT DDC

STEP D L K C CD ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE  
HOURSPFC  
TIMESTD  
HOURS

DLY PCT C

00010	S	E	YH	EA	E	1	ESTD	1.00	PERCENT ENGR 99.9	DEB MAIN WHEEL ASSEMBLY	.56		.56	
0001			YH	01	00			1.00		PART NUMBER/VER	.000	.000	.000	0
0010									3-1266-3	1670011626267				
0020									4594000-1170	1670011626267				
0020			YH	01	01			1.00		FINAL WHEEL ASSEMBLY MED/BRK	.467	.096	.566	100
0010	E								RWE-AW-TF	4.00 REPLACE THERMAL FUSES	.06162		.296	
0020	E								RWE-AW-H2	1.00 INSTL SEGMENTED HEAT SHIELD	.02429		.029	
0030	E								RWE-AW-K2	9.00 INSTL BRAKE KEY/MULTI-SCREW	.01642		.176	
0040	E								RWE-AW-T1	4.00 INSTL UNOBSTRUCTED TIE BOLT	.00975		.047	
0050	E								RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DDC	.01001		.012	
9000			YH	01	25			1.00		LABOR STANDARDS HISTORY	.000	.000	.000	0
0900										LLOYD A.HARGIS MANEL 73357				

TO INTERROGATE LABCR STANDARDS, INPUT

RCC FRD NRCP NR

&lt;---X---X---&gt;

1234567590123456 ELSE PUT IN END



000000 0-5 M WHL ASSY.

OPER TECH 5 5 W F RF 4/5 REV

STEP 3 L K O 00 ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE  
HOURS

RFD  
TIME

STD  
HOURS

0.000000

RM101	S	E	YH	EA	5	3	83706	1.00	PERCENT ENGR 64.5	059 MAIN WHEEL ASSEMBLY	.13		.13	
0001			YH	01	00			1.00		PART NUMBER/NSN	.000	.000	.000	0
			0010						3-1256-3	1630011826267				
			0020						4394000-1170	1630011826267				
0010			YH	01	21			1.00		WHEEL MATCH UP	.110	.023	.134	100
0010	E							1.00	GET EASY AND PLACE EXACT		.00097		.001	
0020	E							1.00	UNPK PARTS-BK KEY-SNAP RING		.08237		.059	
0030	N							1.00		MATCH WHEEL HALFS 2 HALFS	.01700		.020	
0040	E							1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.012	
9000			YH	01	25			1.00		LABOR STANDARDS HISTORY	.000	.000	.000	0
0900									LLOYD A.HARGIS MANEL 73357					

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NRDP NR

<---X---X--->

1234567890123456 ELSE PUT IN END

501014 CHE Y WHL ASBY.

OPER TECH-318 W F FR AVR REV

SLR 714 48 1 PA SUPPORT 000

STEP 2 L 40 00 ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE  
HOURS

PPC  
TIME

STD  
HOURS

ELY  
ELY PCT C

FRONT	15	E	35	BA	5	3	85006	1.00	PERCENT ENGR 89.9	05A MAIN WHEEL INNER	.00		.00	
0001			35	01	00			1.00		PART NUMBER/NEW	.000	.000	.000	0
0010									300-10P-1	1670011084044				
0100			35	01	25			1.00		PAINT WHEEL	.267	.067	.074	4.0 100
0010	E						GPL-PA-01	4.00	INST NONTHEADED PLSTD PLUS		.00067		.004	
0020	E						BIG-SP-M1	1.00	MASK & UNMASK MEDIUM PART		.01242		.015	
0030	E						RWB-DH-W1	1.00	HANG WHL HLF ON PAINT CONVYR		.02336		.027	
0040	E						RWS-SC-02	1.00	PNT WHL HALF-ZINC CHROMATE		.11374		.144	
0050	E						RWB-SC-P3	1.00	PNT WHL HALF (2ND COAT)	POLY 2 COATS	.10214		.127	
0060	E						RJP-PW-R1	1.00	REM RFL PAPRWK SIGN OFF DOC		.01001		.012	
9000			35	01	25			.01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010									06FEB85 NEW REQUIREMENT/INITIAL INPUT					
0900									N MONROE/MANEAA					

TO INTERROGATE LABOR STANDARDS. INPUT

RCC FRD KROF NR

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1234567890123456 ELSE PUT IN END



901014 0-5 M WEL ASBY.

TECH 8 B W P PP ARE REV

ELC 0 0 45 A PA SUPPORT

STEP 0 L K 0 00 ELEMENT FACT

DESCRIPTION  
STORED SUPPLEMENTAL  
SABE EFF STD  
HOURS TIME HOURS DLY PCT C

PP104	S	E	35	EA	5	J	88308	1.00	PERCENT ENGR 99.9	005 MAIN WHEEL OUTER	.33		.33		
0001			35	01	00			1.00		PART NUMBER/NSN	.000	.000	.000		0
0010									300-328-1	1630011084043					
0100			35	01	25			1.00		PAINT WHEEL	.267	.067	.334	4.0	100
0010	E						SPL-PA-01	4.00	INST NONTHEADED PLSTD PLUG		.00093		.004		
0020	E						SIG-SF-M1	1.00	MASK & UNMASK MEDIUM PART		.01242		.015		
0030	E						RWB-QH-W1	1.00	HANG WEL HLF ON PAINT CONVR		.02336		.029		
0040	E						RWB-SC-02	1.00	PNT WEL HALF-ZINC CHROMATE		.11574		.144		
0050	E						RWB-SC-P3	1.00	PNT WEL HALF (2ND COAT)	POLY 2 COATS	.10214		.127		
0060	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DDC		.01001		.012		
9000			35	01	00			.00		LABOR STANDRD HISTORY	.000	.000	.000		0
0900									8 APR. 1988 RICHARD G. MARTIN	MANEL-73357-MRPII					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRPP NR

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901014 CHS M WHL ASSY.

OPER TECH S B W F 55 APR REV

EUS T K 48 4 FA SUPPORT EDC

STEP D L K O DO ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE  
HOURSSTD  
TIMESTD  
HOURS

PLY PCT C

PS104	S	N	YH	EA	5	J	92008	1.00	PERCENT ENGR 54.9	055 MAIN WHEEL OUTER	.80		.80	
0001			YH	01	00			1.00		PART NUMBER/NSN	.000	.000	.000	0
			0010						300-323-1	1630011084043				
0095			YH	01	21			1.00		PREINSPECTION WHEEL HALF	.015	.003	.019	2
			0010	E			RWB-JP-W2	1.00	PREP TO ASSY OR DISSY WHEEL		.00442		.005	
			0020	E			KAL-BC-46	1.00	INSPECT VISUAL		.00115		.001	
			0030	E			RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.012	
0095			YH	01	21			1.00		RACE INSTALLATION WHL/HALF	.178	.037	.216	27
			0010	E			RWB-BC-03	1.00	INSTALL BEARING CUPS		.16338		.203	
			0020	E			RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.012	
0110			YH	01	21			1.00		INSTALL SAFETY VALVE	.260	.055	.315	39
			0010	N				1.00		INSTALL SAFETY VALVE	.25000		.302	
			0020	E			RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.012	
0120			YH	01	21			1.00		TEST SAFETY VALVE	.060	.013	.073	9
			0010	N				1.00		TEST SAFETY VALVE	.05000		.060	
			0020	E			RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.012	
0122			YH	01	21			1.00		BALANCE WHEEL HALF	.111	.023	.134	17
			0010	E			GPL-PD-01	4.00	REM NONTHEADED PLASTIC PLUG		.00339		.016	
			0020	E			GMC-MT-D1	1.00	REMOVE MASKING TAPE		.00191		.002	
			0030	E			RWB-CH-W2	1.00	REMOV WHL HLF F/PAINT CONVDOR		.00833		.010	
			0040	E			RWB-BB-01	1.00	BALANCE WHEEL HALF		.07734		.093	
			0050	E			RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.012	
0123			YH	01	21			1.00		INSTALL SEALS & RETAINERS	.041	.009	.050	6
			0010	E			RWB-AW-B1	1.00	INSTL BEARING/SNAP RING SECURED		.02459		.029	
			0020	E			RWB-AW-C1	1.00	INSTL TIRE CHANGE DATA PLATE		.00672		.008	
			0030	E			RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.012	
9000			YH	01	00			.00		LABOR STANDARD HISTORY	.000	.000	.000	0
0900									8 APR. 1988 RICHARD B. MARTIN MANEL-73357-MRP11					

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NRDP NR

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90101A C-5 M WPL ASSY.

OPER TECH E S W F FF A/R REV

315 T L #R A RA SUPPORT

STEP D L K C DO ELEMENT

DOO

FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE

HOURS

FFD

TIME

STD

HOURS

4

DLY POT

PP101	E	N	3S	EA	5	K	85306	1.00	PERCENT ENGR 37.9	CSB MAIN WHEEL ASSEMBLY	.41		.41		
0001			3S	01	00			1.00		PART NUMBER/NSN	.000	.000	.000		6
									3-1269-3	1630011826267					
									4894000-1170	1630011826267					
0030			3S	01	25			1.00		PAINT TOUCH UP SM & MED	.063	.016	.080		19
0010	E						RWB-FT-02	1.00	FINAL & TUCH UP MED/SML WHEL		.05395		.067		
0020	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOO		.01001		.012		
0040			3S	01	25			1.00		FINAL ACCEPTANCE OF W.C.D.	.132	.033	.166		40
										FINAL	.08000		.100		
							GJP-FF-35	1.00	FILL OUT FORM 424 & ATTACH		.05255		.065		
0050			3S	01	25			1.00		FINAL VISUAL INSPECTION	.137	.034	.171		41
										FINAL VISUAL INSPECTION	.12700		.159		
							RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOO		.01001		.012		
9000			3S	01	25			1.00		LABOR STANDARDS HISTORY	.000	.000	.000		0
0900									LLOYD A.HARGIS MANEL 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRGP NR

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2MNPRA90101ARA103

PC0014 C-5 \* WEL ASSY.

R02 MNPA

451-4-450

37192

OPER TECH 6 B A F F REV

STEP	TIME	DESCRIPTION	BASE HOURS	FFD TIME	STD HOURS	PLY POT
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RA103	S E JA EA 1	J 88308	1.00	PERCENT ENGR 99.9	MACH WHEEL HALF INNER C-55	2.18		2.18	
0001	JA 01	00	1.00		PART NUMBER/NSN	.000	.000	.000	0
0010				300-329-1	1630011064044				
0009	JA 01	15	.05		REMOVE BROKEN SCREWS	.235	.002	.014	1
0010 E		RBW-SU-B1	.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525		.158	
0020 E		RSG-JP-03	1.00	PREP HAND DRILL FOR USE		.00561		.009	
0030 E		GTL-SE-A1	2.00	DRILL & EASYOUT SCR TO .25IN2 SCREWS		.02540		.053	
0040 E		GTL-TH-A1	2.00	TAP HOLE TO 0.25 IN THRD DIA2 HOLES		.01427		.032	
0050 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DDC		.01001		.011	
0044	JA 01	15	1.00		POLISH BASE DRV KEY HOLES	.300	.045	.345	16
0010 E		RBW-SU-B1	.50	S/U FOR BENCH WORK GENERAL	PRO RATE 2 PARTS	.27525		.158	
0020 E		ZPG-JP-S1	1.00	PREP TO POLISH BASE HOLES		.00495		.005	
0030 E		RHY-RC-F2	9.00		POLISH BASE HOLES	.01582		.163	
0050 E		GCL-CA-A4	4.00	CLEAN BLIND HOLE WITH AIR		.00126		.005	
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DDC		.01001		.011	
0045	JA 01	15	1.00		REMOVE INSERTS	.176	.027	.203	9
0010 E		RBW-SU-B1	.50	S/U FOR BENCH WORK GENERAL	PRO RATE 2 PARTS	.27525		.158	
0020 E		JLR-AS-D5	1.00	RMVE SMALL SPRING W/TWEEZERS	8 OCCUR	.01232		.014	
0030 E		GTL-TH-A1	1.00	TAP HOLE TO 0.25 IN THRD DIA		.01427		.016	
0040 E		KTL-TT-03	1.00	TAP EACH ADDITIONAL THREAD		.00130		.001	
0050 E		GCL-CA-A4	1.00	CLEAN BLIND HOLE WITH AIR		.00126		.001	
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DDC		.01001		.011	
0050	JA 01	15	.07		O/S HOLE ON MILL/MED PART	.835	.009	.067	3
0010 E		RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTR	PRORATE OVER 4 PARTS	.80167		.230	
0020 E		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		KMM-BA-LC	1.00	BORE HOLE 6 X 1 1/2 GROUP 1 USE PROPER ELEMENT/TABLE		.26418		.303	
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DDC		.01001		.011	
0056	JA 01	15	.05		BEARING BORE REP - JIG BORE	.835	.006	.048	2
0010 E		RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTR	PRORATE OVER 4 PARTS	.80167		.230	
0020 E		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		KMM-BA-LC	1.00	BORE HOLE 6 X 1 1/2 GROUP 1 USE PROPER ELEMENT/TABLE		.26418		.303	
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DDC		.01001		.011	
0057	JA 01	15	1.00		BEARING BORE SEAT REP, MED	.773	.116	.889	41
0010 E		RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTR	PRORATE OVER 4 PARTS	.80167		.230	
0020 E		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP	JIG BORE	.15776		.181	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		KMM-BA-LA	1.00	BORE HOLE 6 X 1 1/2 GROUP 1 USE PROPER ELEMENT/TABLE		.20205		.232	
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DDC		.01001		.011	
0059	JA 01	15	.07		O/S HOLE ON MILL/LARGE PART	.894	.009	.072	3
0010 E		RML-SU-V3	.25	S/U VERT MIL BORE FXTR	HOISTPRORATE OVER 4 PARTS	1.03687		.298	
0020 E		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		KMM-BA-LC	1.00	BORE HOLE 6 X 1 1/2 GROUP 1 USE PROPER ELEMENT/TABLE		.26418		.303	
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DDC		.01001		.011	
0073	JA 01	15	.07		INST BEARING BORE BUSH & CLF	.077	.001	.006	0
0010 E		RBW-SU-B1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18659		.053	
0020 E		RBW-SU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	

00070 E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC	.01001	.011	
0074	JA 01	15	.05	MACH BEARING BORE BUSHING	.236	.002
0010 E	RLA-BU-ST	.25	SET UP SMALL MEDIUM LATHE	.49962	.143	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006	.011	
0030 E	KML-TA-JC	1.00	DIA 5.00-6.00 REM .033-.250	.09193	.105	
0040 E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC	.01001	.011	
0075	JA 01	15	.07	INST BEARING BORE BUSH & CUP	.077	.001
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669	.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC	.01001	.011	
0077	JA 01	15	.10	INST BEARING BORE BUSH & CUP	.077	.001
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669	.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC	.01001	.011	
0079	JA 01	15	.05	MACH BEARING BORE BUSHING	.236	.002
0010 E	RLA-BU-S3	.25	SET UP SMALL MEDIUM LATHE	.49962	.143	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006	.011	
0030 E	KML-TA-JC	1.00	DIA 5.00-6.00 REM .033-.250	.09193	.105	
0040 E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC	.01001	.011	
0079	JA 01	15	.07	INST BEARING BORE BUSH & CUP	.077	.001
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669	.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC	.01001	.011	
0080	JA 01	15	1.00	INSTALL HELICOILS	.431	.065
0010 E	RBW-BU-H1	1.00	SET UP TO INSTALL HELICOILS	.31093	.357	
0020 E	RBW-TR-H1	4.00	INSTALL HELICOIL INSERT	.02763	.127	
0030 E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC	.01001	.011	
9000	JA 00	15	.00	LABOR STANDARD HISTORY	.000	.000
0010						
0011						
0012						
0900						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRJP NR

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FORM 12-1-88

TECH 5 B W F FF A/S REV

SLR T W AS A FA SUPPORT

STEP D L K O DO ELEMENT

DOC

FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE

HOURS

FFD

TIME

STD

HOURS

BLV FOT C

RA104	S	N	JA	EA	1	2	88308	1.00	PERCENT ENGR 70.3	MACH WHEEL HALF OUTER C-5B	1.90		1.90	
0001			JA	01		00		1.00		PART NUMBER/NSN	.000	.000	.000	0
			0010						300-325-1	1630011094043				
0040			JA	01		15		.05		THREAD INSERT REPAIR	.835	.006	.048	3
			0010	E			RBW-SU-61	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
			0020	E			RBW-TR-61	8.00	DRILL TAP & INSTALL SLIMERT4 SCREWS-4 HOLES		.06579		.632	
			0030	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0043			JA	01		15		.05		REMOVE BROKEN SCREWS	.338	.003	.019	1
			0010	E			RBW-SU-61	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
			0020	E			RSG-JP-03	1.00	PREP HAND DRILL FOR USE		.00861		.009	
			0030	E			GAE-TL-02	2.00	DRILL W/HND DRILL TO 1/4 IN DRILL 2 HOLES		.00871		.020	
			0040	E			JLR-AS-08	2.00	REMV 2 SCREWS EASYOUT		.01232		.028	
			0050	E			GCL-CA-A4	2.00	CLEAN BLIND HOLE WITH AIR 2 HOLES		.00126		.002	
			0060	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0045			JA	01		15		.93		SAFETY VLVE HOLE REP	.983	.137	1.052	58
			0010	N				.50		S/U BORE FXTR(RML-SU-V2)	.98400		.565	
			0020	E			RML-HP-H1	1.00	PART ON/OFF MACH HAND NO RAP		.03068		.035	
			0030	E			RML-AL-AA	1.00	ALIGN HORIZ AXIS ROD		.06265		.072	
			0040	E			RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
			0050	E			RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
			0060	E			RML-BA-AB	1.00	BORE HOLE 1 X 1 GROUP 1		.18482		.212	
			0070	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0046			JA	01		15		.09		VALVE STEM HOLE REPAIR	.642	.009	.066	4
			0010	E			RDR-SU-R1	1.00	S/U TO D/S BOSSES RAD DRILL		.56378		.648	
			0020	E			KML-DR-K8	1.00	DRILL HOLE 1/2 DIA 1 DEEP		.06857		.078	
			0030	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0055			JA	01		15		.05		BEARING BORE REP,PENSOTTI	.508	.004	.029	2
			0010	N				1.00		SET UP PENSOTTI	.16700		.192	
			0020	E				1.00	4 .26 MACHINE BEARING BORE		.29333		.337	
			0030	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC/		.01001		.011	
			0040	E			RPL-MH-P1	1.00	GET PALLET JACK & MOVE PARTS/		.03815		.043	
0058			JA	01		15		.05		BEARING BORE SEAT REP,MED	.787	.006	.045	3
			0010	E			RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTR PRORATE OVER 4 PARTS		.80167		.230	
			0020	E			RML-TP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP JIG BORE		.15776		.181	
			0030	E			RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
			0040	E			RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
			0050	E			RML-BA-CD	1.00	BORE HOLE 2 X 2 GROUP 1 USE PROPER ELEMENT/TABLE		.21626		.248	
			0060	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0072			JA	01		15		.05		INST STRAIGHT BUSH NO POLISH	.077	.001	.004	0
			0010	E			RBW-BU-61	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS		.18669		.053	
			0020	E			RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
			0030	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0074			JA	01		15		.05		MACH BEARING BORE BUSHING	.236	.002	.014	1
			0010	E			RLA-SU-63	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS		.49962		.143	
			0020	E			RLA-TP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
			0030	E			KML-TA-JC	1.00	DIA 5.00-6.00 REM .033-.250		.09193		.105	
			0040	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0076			JA	01		15		.05		INST BEARING BORE BUSH & CLP	.077	.001	.004	0
			0010	E			RBW-BU-61	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS		.18669		.053	
			0020	E			RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
			0030	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0077			JA	01		15		.10		INST STRAIGHT BUSH NO POLISH	.077	.001	.009	0
			0010	E			RBW-BU-61	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS		.18669		.053	

TIME	CODE	DESCRIPTION	UNIT	QUANTITY	UNIT PRICE	TOTAL	REMARKS
0020	E	RBW-BU-A4	1.00	1.00	.02062	.027	INSTALL ONE STRAIGHT BUSHING
0070	E	RJP-PW-R1	1.00	1.00	.01001	.011	REM RPL PAPRAWK SIGN OFF DOC
0075	JA 01	15	1.00	1.00	.078	.002	MACH BEARING BORE BUSHING
0010	E	RJP-SU-S3	.25	.25	.48962	.147	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS
0020	E	RCA-HF-D1	1.00	1.00	.01006	.011	1ST PART IN-OLT SCROLL CHUCK
0030	E	MML-TP-JC	1.00	1.00	.09193	.105	DIA 5.00-6.00 REM .033-.250
0040	E	RJP-PW-R1	1.00	1.00	.01001	.011	REM RPL PAPRAWK SIGN OFF DOC
0079	JA 01	15	1.00	1.00	.077	.001	INST BEARING BORE BUSH & CUP
0010	E	RBW-BU-B1	.25	.25	.12669	.033	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS
0020	E	RBW-BU-A4	1.00	1.00	.02062	.023	INSTALL ONE STRAIGHT BUSHING
0030	E	RJP-PW-R1	1.00	1.00	.01001	.011	REM RPL PAPRAWK SIGN OFF DOC
0080	JA 01	15	1.00	1.00	.431	.065	INSTALL HELICOILS
0010	E	RBW-SU-H1	1.00	1.00	.31093	.337	SET UP TO INSTALL HELICOILS
0020	E	RBW-TR-H1	4.00	4.00	.02763	.127	INSTALL HELICOIL INSERT
0030	E	RJP-PW-R1	1.00	1.00	.01001	.011	REM RPL PAPRAWK SIGN OFF DOC
9000	JA 01	15	.01	.01	.000	.000	LABOR STD HISTORY
0010							21MAY85 DWN GRD TO N STD (TM WAS 2.40)
0020							09 APRIL 87 RM SUBOPS 0044-0110 NLD OLD STD 2.
0900							D.PARKER TECHN MANEAA

TO INTERROGATE LABOR STANDARDS, INPUT

RCC FRD NRDP NR

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1234567890123456 ELSE PUT IN END

CHNFR090101ARD103

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS  
ROD MNFR

11/14/88  
481-4-483

4-ED483-MM1-DV-M4E PAGE 0001  
87188

90101A D-S M WHL ASBY.

OPER TECH S S W P FF A/R REV

SUB T N #R A PA SUPPORT

STEP D L N D DO ELEMENT FACT

DESCRIPTION

STORED

SUPPLEMENTAL

BASE  
HOURS

FFD  
TIME

STD  
HOURS

BLV POT C

RD103	S	E	UP	EA	S	J	88308	1.00	PERCENT ENGR 99.9	PLT. OSBM WHEEL HALF, INNER	.94		.94	
0001			UP	01		00		1.00		PART NUMBER/NSN	.000	.000	.000	0
			0010						300-329-1	1630011084044				
0050			UP	01		24		1.00		SHOT PEEN MED PART/MASK	.301	.072	.374	40
			0010	E			RPL-MA-AA	1.00	MASK UNMASK EXT PLATE AREA		.12999		.161	
			0020	E			RPL-SF-M1	1.00	SHOT PEEN SMALL/MED PART		.16131		.200	
			0030	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
0070			UP	01		24		1.00		ANDDIZE MED PART	.460	.111	.571	.9 50
			0010	E			RWB-CV-D1	1.00	VAPOR CL (DEBR)HOOK/BASKET		.08709		.107	
			0020	E			ZPL-AN-M1	1.00	ANDDIZE MEDIUM SIZE PART		.36341		.450	
			0030	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
9000			UP	01		00		.00		LABOR STANDRD HISTORY	.000	.000	.000	0
0500									8 APR. 1988 RICHARD B. MARTIN MANEL-73357-MRP11					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

<---X---X--->

1234567890123456 ELSE PUT IN END

RD104 0-5 M WEL ASSY.

OPER TECH S B W F FF A/R REV

SUB T R W A R4 SUPPORT

STEP D L N D DO ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

PAGE

REF

STC

A

HOURS

TIME

HOURS

DLY FCT C

RD104	S	E	UP	EA	B	J	83308	1.00	PERCENT ENGR 99.9	PLT 05B M WHEEL HALF OUTER	.94		.54	
0001			UP	01		00		1.00		PART NUMBER/SEN	.000	.000	.000	0
0010									300-328-1	1630011084043				
0030			UP	01		24		1.00		SHOT FEEN MED PART/MASK	.301	.072	.374	40
0010 E								1.00	MASK UNMASK EXT PLATE AREA		.12999		.161	
0020 E								1.00	SHOT FEEN SMALL/MED PART		.16131		.200	
0030 E								1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
0070			UP	01		24		1.00		ANODIZE MED PART	.460	.111	.571	.8 60
0010 E								1.00	VAPOR CL (DEGR)HOOK/BASKET		.08709		.107	
0020 E								1.00	ANODIZE MEDIUM SIZE PART		.36341		.450	
0030 E								1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
9000			UP	01		24		.00		LABOR STANDARD HISTORY	.000	.000	.000	0
0010									3JUN66 REWROTE STD TO MATCH 958 WORK PREVIOUSLY					
0011									DONE ON OPERATION XNPRC <OLD STD .425>					
0900									KERRY CDP MANEL TECHN 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRDP NR

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1234567890123456 ELSE PUT IN END

90101A C-5 M WEL 48BY.  
OPER TECH S S A F 55 A/R REV

SUB	T R	HR A FA SUPPORT	DOC	DESCRIPTION	PAGE	FRD	STD	
STEP D L	K O DO ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
W0001	S N KI EA 5	C 85306	1.00	PERCENT ENGR 54.9	OSB MAIN WHEEL INNER	.59	.59	
0001	KI 01 00	1.00		PART NUMBER/NSN	.000	.000	.000	0
0010				3-1269-3	1630011626267			
0020				4894000-1170	1630011526267			
0007	KI 01 27	1.00		CHEM CLEAN WHEEL ALUM	.116	.031	.147	2.6 25
0010 N	ZLG-CL-M1	.50		LOAD & UNLOAD CARRIER CLEAN	.21200		.134	
0020 E	RJP-PW-R1	1.00		REM RPL PAPRWRK SIGN OFF DOC	.01001		.012	
0008	KI 01 27	1.00		BLAST CLEAN WHEEL MED	.217	.059	.277	46
0010 E	RPL-SE-M2	1.00		SANDBLAST MED PART WALK-IN B	.10180		.129	
0020 N	ZLG-CL-M1	.50		LOAD & UNLOAD CARRIER CLEAN	.21200		.134	
0030 E	RJP-PW-R1	1.00		REM RPL PAPRWRK SIGN OFF DOC	.01001		.012	
0011	KI 01 27	1.00		ANODIZE STRIP WHEEL ALUM	.136	.037	.173	.7 29
0010 E	ZCD-ST-S1	1.00		ANODIZE STRIP	.12630		.160	
0030 E	RJP-PW-R1	1.00		REM RPL PAPRWRK SIGN OFF DOC	.01001		.012	
9000	KI 01 27	.01		LABOR STD HISTORY	.000	.000	.000	0
0010				18JUL85 MOVED N&B TO HB SKL (TM WAS .66)				
0900				D.PARKER TECHN MANEAA				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC FRD NROP NR

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1234567890123456 ELSE PUT IN END

90101A 2-5 F WHL ASSY.

OPER TECH 8 6 W 5 FF A/R REV

SLB T Y HA 4 FA SUPPORT

STEP 3 L K O DO ELEMENT

DESCRIPTION  
STORED SUPPLEMENTAL  
BASE HOURS  
PFD TIME  
STD HOURS  
DLY PCT D

W0001	S	E	HE	EA	5	J	B2300	1.00	PERCENT ENGR 99.9	DISSY WHEEL CSA M	211E	.97		.97	
0001			HE	01	00			.00		PART NUMBER/NSN		.000	.000	.000	0
0010									4894000-1170	1630011826267					
0005			HE	01	25			1.00		DISASSEMBLE		.606	.152	.758	75
0010	E						RWB-JP-W1	1.00	PREP TO DISASSEMBLE WHEEL			.01630		.020	
0020	E						RWB-HP-EB	1.00	HNDL E/I PARTS (ALL WHEELS)EA			.02265		.023	
0030	E						RWB-HT-C3	1.00	HANDLING TOOLS PER END ITEM			.13837		.172	
0040	E						RWB-DW-T1	18.00	REM UNDBSTR WHL TIE BOLT 18 EACH			.01056		.237	
0050	E						RWB-DW-K1	9.00	REM BRAKE KEY (ONE RET SCW) 8 EACH			.01091		.122	
0060	E						RWB-DW-C2	2.00	REM DATA PLATE & STAMP WHL 2 EACH			.03067		.076	
0070	E						RWB-DW-B1	2.00	REM BEARING (SNAP RING SEC) 2 EACH			.01227		.030	
0080	E						RWB-DW-M1	1.00	DTS WHL (V/L-L & M WHEELS)			.04265		.053	
0090	E						RWB-DW-H1	1.00	REM HEAT SHIELD (SINGLE PC)			.00217		.062	
0100	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.012	
0006			HE	01	25			1.00		REMOVE BEARING CUP		.171	.043	.214	22
0010	E						RWB-BC-R1	2.00	REMOVE BEARING CUP			.02811		.070	
0020	E						RWB-MH-02	1.00	LOAD HOOK W/WHEELS F/CLENING			.10532		.131	
0030	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.012	
9000			HE	01	25			.01		LABOR STD HISTORY		.000	.000	.000	0
0010									10JUN85 CHANGED SKL CODE NO TM CHNG						
0020									OLD STANDARD .91						
0900									26 SEPT 1989 MRPII RICHARD G. MARTIN MANEL 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC FRD NR0P NR

<---X---X--->

1234567890123456 ELSE PUT IN END

901014 C-E Y WEL ASBY

OPER TECH S S W F RF AVE REV

SUB T N #R A FA SUPPORT

STEP D L K C D2 ELEMENT

COO

FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE

HOURS

RFI

TIME

STD

HOURS

PLY

PLY

WE100	E	N	D1	EA	5	J	89308	1.00	PERCENT ENGR 12.3	CEE MAIN WHEEL INNER	.51		.51		
0001			D1	01	00			1.00		PART NUMBER/NO	.000	.000	.000		0
			0010						300-129-1	1630011034044					
0019			D1	01	27			1.00		NICK & BURR WHEEL MED/HALF	.250	.068	.018		82
0010	E						RLB-RS-NJ	1.00	NICK & BURR FTS-CONST F/PREP		.02312		.025		
0020	N							1.00		NICK & BURR WHEEL MED/HALF	.21687		.075		
0030	E						RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.012		
0030			D1	01	15			1.00		E & I AND ROUTE WHEEL	.167	.025	.193		38
0010	N							1.00		E&I AND ROUTE WHEEL HALF	.14919		.171		
0020	E						RWB-CH-W2	1.00	REMY WHL HLF F/PAINT CONVOYOR		.00833		.009		
0030	E						RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011		
9000			D1	01	15			.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010									28FEB85 NEW REQUIREMENT/INITIAL INPUT						
0900									N MONROE MANEAA 73.37						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRO NRDP NR

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1234567890123456 ELSE PUT IN END

2MNF34

R01004 CHE M WEL REBN.

RCC MRPGW

4W1-4-497

87198

OPER TECH E B

W F AF 4/R REV

SUB

STEP 3 L

R0 4 RD SUPPORT

DOC

W D DD ELEMENT

FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE

PRD

STD

HOURS

TIME

HOURS

OLY TOT C

WE104	E	N	DI	EA	E	J	85308	1.00	PERCENT ENGR 12.0	CSB MAIN WHEEL OUTER	.51		.51	
0001			DI	01		00		1.00		PART NUMBER/NSN	.000	.000	.000	0
									300 725-1	1830011084 43				
0015			DI	01		27		1.00		NICK & BURR WHEEL MED/HALF	.250	.066	.316	82
									RLG-RB-NC	1.00 NICK & BURR PTS-CONST F/PRP	.02312		.029	
										1.00 NICK & BURR WHEEL MED/HALF	.21687		.275	
									RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.012	
0030			DI	01		15		1.00		E & I AND ROUTE WHEEL	.167	.025	.193	38
										1.00 E&I AND ROUTE WHEEL HALF	.14919		.171	
									RWB-CH-W2	1.00 REMV WHL HLF F/PAINT CONYOR	.00833		.009	
									RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
9000			DI	01		00		1.00		LABOR STANDARD HISTORY	.000	.000	.000	0
0900										8 APR. 1988 RICHARD G. MARTIN MANEL-73357-MRP11				

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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# LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/01/89

A-E0468-MM1-DY-M45 PAGE 0001

90101A C-S M WHL ASSY.

RCC MNPNA

4B1-4-493

87198

OPER TECH S S W F FF A/R REV

STEP	SUB	T K	#R A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
MNPNA	S	X	DB	EA	2	J 88308	1.00 PERCENT ENGR 99.9				
0015			DB	01	11		CSB MAIN WHEEL INNER	.31		.31	
0010	E					ZLG-ND-M6	NDI TIE BOLTS 1ST TIME	1.005	.014	.145	46
0020			DB	01	11		MAGNAGLO INSP SHALL OBJECT	.09138		1.115	
0010	E					ZLG-ND-M6	NDI DRIVE KEYS 1ST TIME	.822	.012	.119	37
2000			DB	01	00		MAGNAGLO INSP SHALL OBJECT	.09138		.912	
0010							PART NUMBER/NSN	.000	.000	.000	0
0020						3-1268-3	1630011826267				
2001			DB	01	11		4694000-117C				
0010	E					ZYGLO INSP MED PART BLD 507	1630011826267	.273	.030	.304	.7 96
0020	E					RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.13177		.292	
9000			DB	01	00		LABOR STANDARD HISTORY	.01001		.011	
0900							21 MAR. 1988 MRP11-RICHARD G. MARTIN-MANEL-73357	.000	.000	.000	0

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD MROP NR

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1234567890123456 ELSE PUT IN END

BLDG 505/507

F-4 NOSE WHEEL

MISCELLANEOUS

MISCELLANEOUS

TYTAYITAYITM

107-117-1171

715

**SYNTHESIS**

LD=LEAD

五

16267A

ROUTED	LOW LEVEL	PART	STOCK	VENDOR	NOMENCLATURE	UNITS	PER	OF	DATE	REV	EFFECTIVITY	TECH	ORD	PENDING	PENDING	PENDING
ITEM	CODE	NUMBER	NUMBER	CODE		ASSY	MEAS			LEVEL	CONTROL	NUMBER		ACTION	ACTION	ACTION
	0	Z20A123	1630006021432	23233	IF-4 NOSE WHEEL ASSEMBLY	11	EA									
	1.1	Z20A282	1630011611191	23233	...WHEEL HALF ASSEMBLY (INBOARD)	11	EA									
STL	1.2	1L305610	13110002770372	60038	...CLIP, BEARING	11	AR1EA									
VAL	1.2	Z20A284	53300097360620LE	73808	...RAFFLE, GREASE RETAINER	11	EA									
STL	1.2	219A189-1	16300091531183	73808	...WEIGHT, BALANCE .25oz	11	AR1EA									
STL	1.2	219A189-2	16300091531184	73808	...WEIGHT, BALANCE .50 oz	11	AR1EA									
STL	1.2	219A189-3	16300091531185	73808	...WEIGHT, BALANCE .75oz	11	AR1EA									
STL	1.2	219A189-4	16300091731110	73808	...WEIGHT, BALANCE 1oz	11	AR1EA									
	1.2	AW520-10R14	5305007716012	88044	...SCREW, WEIGHT	11	AR1EA									
	1.2	AW960-10L	5310001670834	88044	...WASHER, WEIGHT	11	AR1EA									
	1.2	W620364-1032C	5310002732025	96906	...NUT, WEIGHT	11	AR1EA									
STL/STW	1.2	Z20A286	53300097360620LE	73808	...SEAL, GREASE (I.B.)	11	EA									
STL	1.2	Z20A247	5365005346651	73808	...RING RETAINING (I.B.)	11	EA									
	1.2	N.P.L.	N.S.L.		...WHEEL HALF SUBASSY (INBOARD)	11										
	1.3	N.P.L.	N.S.L.		...SLEEVE & CLIP ASSY (PSEUDO)	11	AR1									
	1.4	Z20A401	3120004687091LE	73808	...SLEEVE, BEARING CLIP	11	EA									
	1.4	1L305610	3110002770372	60038	...CLIP, BEARING	11	EA									
	1.3	Z20A282	N.S.L.	23233	...WHEEL HALF (INBOARD)	11										
STL	1.1	Z20A283	1630011532016	23233	...WHEEL HALF ASSEMBLY (OUTBOARD)	11	EA									
	1.2	1L102810	3110001861114	60038	...CLIP, BEARING	11	AR1EA									
STL	1.2	219A189-1	16300091531183	73808	...WEIGHT, BALANCE .25oz	11	AR1EA									
STL	1.2	219A189-2	16300091531184	73808	...WEIGHT, BALANCE .50 oz	11	AR1EA									
STL	1.2	219A189-3	16300091531185	73808	...WEIGHT, BALANCE .75oz	11	AR1EA									
STL	1.2	219A189-4	16300091731110	73808	...WEIGHT, BALANCE 1oz	11	AR1EA									
	1.2	AW520-10R14	5305007716012	88044	...SCREW, WEIGHT	11	AR1EA									
	1.2	AW960-10L	5310001670834	88044	...WASHER, WEIGHT	11	AR1EA									
	1.2	W620364-1032C	5310002732025	96906	...NUT, WEIGHT	11	AR1EA									
VAL	1.2	Z20A285	53300097360620LE	73808	...RAFFLE, GREASE RETAINER	11	EA									
STL	1.2	Z20A247	5365005346651	73808	...RING, RETAINING (O.B.)	12	EA									
STL/STW	1.2	Z20A287	53300097360620LE	73808	...SEAL, GREASE (O.B.)	11	EA									
	1.2	N.P.L.	N.S.L.		...WHEEL HALF SUBASSY (OUTBOARD)	11										
	1.3	N.P.L.	N.S.L.		...SLEEVE & CLIP ASSY (PSEUDO)	11	AR1									
	1.4	Z20A403	3120002251936LE	73808	...SLEEVE, BEARING CLIP	11	EA									
	1.4	1L102810	3110001861114	60038	...CLIP, BEARING	11	EA									
	1.3	Z20A283	N.S.L.	23233	...WHEEL HALF (OUTBOARD)	11										
STL	1.2	W620002-5	5310002090026	96906	...WASHER TIE BOLT (ADD 1 IF REPAIRED)	10	AR1EA									
	1.1	TR752-03	2640007267896	79934	...VALVE ASSEMBLY, CHARGING	11	EA									
	1.2	VC5	1650007224525	79934	...CAP, VALVE	11	EA									
	1.2	C4	2640000105861	79934	...VALVE, CORE	11	EA									
	1.2	RC30	53300041978711W	53477	...PACING, O-RING	11	EA									
STL	1.2	TR752	N.S.L.	79934	...STEM, VALVE	11										
	1.1	N.P.L.	N.S.L.		...VALVE & PACKING ASSY (PSEUDO)	11	AR1									
STL	1.2	W627436-3	2640001166208	96906	...VALVE ASSEMBLY OVERSIZE	11	EA									

16-May-58

BLDG 505/507

STL=STEEL  
AL=ALUMINUM  
MAG=MAGNESIUM  
TITA=TITANIUM  
SS-S STL  
SYN=SYNTHETIC  
LD=LEAD

F-4 NOSE WHEEL  
BILL OF MATERIALS  
16267A

\* = MM

ROUTED	LOW LEVEL	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS	UNIT	YIELD	SCRAP	PART	MTC	REV	EFFECTIVITY	TECH	ORD	PENDING	PENDING	PENDING
ITEM	CODE					PER	OF	IRATE	FACTOR	TYPE	CODE	LEVEL	CONTROL	CNG	103	252	ACTION	ACTION
						ASSY	MEAS			R, D, C			DATE	NUMBER				
	1.1	22A288	5330005997735	23233	PACKING O-RING	1	EA											
	1.1	MS29561-262	5330008924263	96906	PACKING O-RING	1	EA					SUB						

(6402A-TIP001)

LA FOR STD S-VIR 10 APR 89

4:37 PM

PROD NBR	REC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
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10207A	XKPAW	XKPAW	X	4N	5	.31	1.00	51
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								51
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MNPGP	DD110	E	YH	5		.01	1.00	5
	PA150	E	YH	5		.28	1.00	28
	PA155	E	YH	5		.28	1.00	28
	PA156	E	YH	5		.13	1.00	13
	PP150	E	SS	5		.33	1.00	33
	PP155	E	SS	5		.33	1.00	33
	PP156	N	SS	5		.42	1.00	42

								1.23
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MNPGW	WD001	N	KI	5		.54	1.00	54
	WD001	E	HE	5		.48	1.00	48
	WE150	N	DI	5		.35	1.00	35
	WE155	N	DI	5		.35	1.00	35

								1.72
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MNPNA	XNPNA	X	DS	2		.12	1.00	12
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MNPRA	R-150	E	JA	1		1.50	1.00	1.50
	RA155	E	JA	1		1.08	1.00	1.08

								2.58
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MNPRC	RC150	E	UP	5		.19	1.00	19
	RC155	E	UP	5		.19	1.00	19

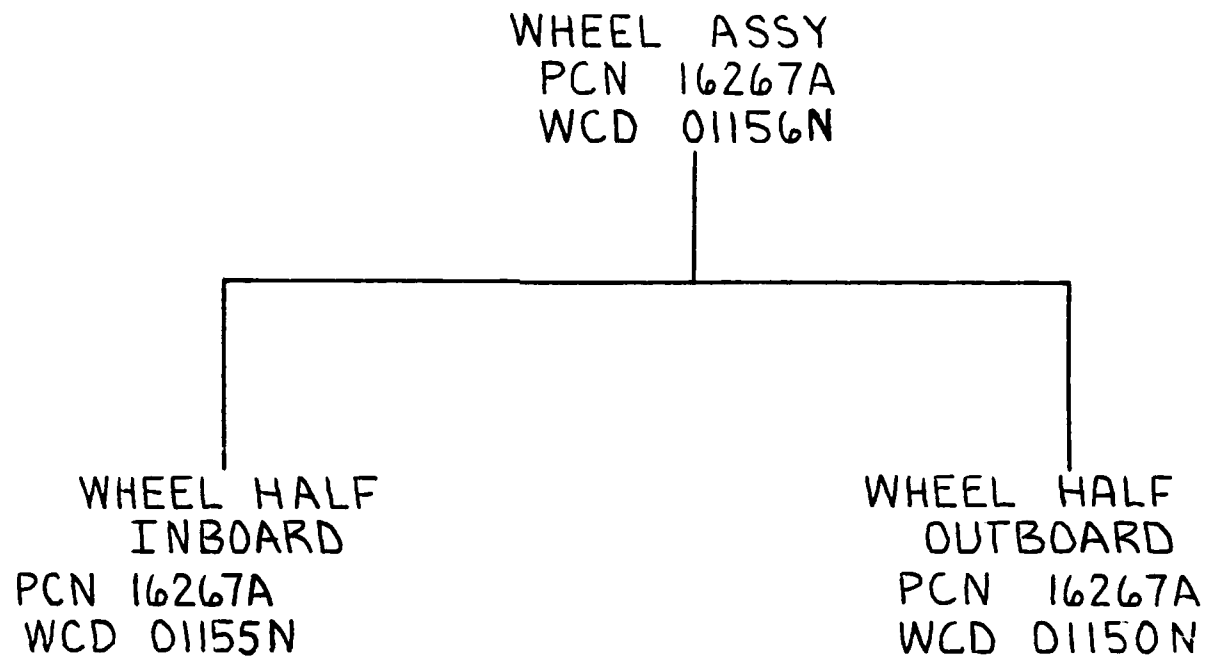
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SERIAL NUMBER LIST

Q	LAN	CONTROL	JOP	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDER	G019
	CH	NUMBER	DESC						FLOM DAYS
JENS	RIGB	15585A	-J	F-106 MLG	BRAKE ASSY	1630-00-165-1029	151806-2	481-4-223	24
JENS	RIGB	15587A	-G-J	F-111 MLG	BRAKE PRESSURE PLATE	1630-00-264-0752	329-16-1	481-2-483	19
JENS	PRIC	15592A	-G-J	KC-135 MLG	WHEEL	1630-00-421-0319	211A24303	483-2-113	30
JENS	RIGB	15601A	-G-J	T-39 MLG	BRAKE ASSY	1630-00-553-4734	9550338-1	481-2-1073	20
JENS	RIGB	15603A	-G-J	KC-135 MLG	BRAKE BACKING PLATE	1630-00-591-8349	2601844	481-4-263	16
JENS	PIGB	15616A	-J	C-141 MLG	BRAKE BACKING PLATE	1630-00-567-0162	9533668	481-2-373	19
JENS	RIGB	15621A	-J	F-106 MLG	BRAKE PRESSURE PLATE	1630-00-671-2838	151804	481-4-223	16
JENS	RIGB	15639A	-G-J	C-130 MLG	BRAKE PRESSURE PLATE	1630-01-005-4188	5002564	481-2-1003	16
JENS	RIGB	15641A	-J	F-4 MLG	BRAKE HOUSING SUB ASSY	1630-00-276-9849	5001896	481-2-1093	23
JENS	RIGB	15642A	-G-J	C-130 MLG	BRAKE BACKING PLATE	1630-01-005-4189	5000263	481-2-1003	19
DELE		15643A	-G-J	F-15 MLG	WHEEL	1630-00-123-8803	17 OCT 88	481-0-73	22
JENS	RIGB	15644A	-J	F-15 MG A/B	BRAKE HOUSING	1630-00-123-8804	5002269	481-2-1123	16
COOP	PRIC	15651A	-J	F-15 MLG	WHEEL	1630-00-558-2584	5000960-2	483-8-23	20
JENS	PRIC	15652A	-G-J	F-15 MLG	WHEEL	1630-01-005-4262	5000864	481-0-73	20
JENS	COOP	15677A		A-7 MLG	STRUT ASSY	1620-01-174-1655	8121017-30	481-90-3	30
JENS	COOP	15678A		A-7 MLG	STRUT ASSY	1620-01-174-3170	8121017-10	481-90-3	02
JENS	PRIC	15686A	-G-J	A-10 MLG	WHEEL	1630-00-596-9637	3-1358	483-4-433	16
JENS	RIGB	15698A	-G-J	C-5A MLG	BRAKE ASSY	1630-01-041-4570	2-1179-4	481-2-1063	26
JENS	RIGB	15728A	-J	C-130 MLG	BRAKE HOUSING	1630-00-937-6604	9543433	481-2-1003	16
JENS	RIGB	15744A	-J	F-15 MG A/B	BRAKE ASSY	1630-01-050-5274	5000913-12	481-2-1123	13
JENS	RIGB	15746A	-J	C-141 MLG	WHEEL	1630-01-081-6687	3-1095	483-7-1043	20
JENS	RIGB	15747A	-J	F-15 MLG	BRAKE BACKING PLATE	1630-00-132-2821	5002483	481-2-1123	16
JENS	RIGB	15749A	-J	F-5 MLG	BRAKE ASSY	1630-00-227-2000	AA318196	481-2-453	20
JENS	RIGB	15752A	-G-J	A-10 MLG	BRAKE ASSY	1630-01-062-7046	5002372-5	481-2-1143	27
JENS	PRIC	15753A	-J	E-3A MLG	WHEEL	1620-01-009-8474	95605718	481-7-1353	20
JENS	PRIC	15757A	-G-J	C-130 MLG	WHEEL	1630-00-914-1329	219A967	483-4-363	23
MART	SHEL	15803A	-G	A-7	HOUSING TRANSFER UNIT	1005-00-239-2929	175F631	1141-7-1-103	20
MART	SHEL	15819A			BREECH MAU-12	1095-00-911-8407	64H13212-3	11829-3-25-2	12
JENS	PRIC	15822A	-J	F-5 MLG	WHEEL	1630-01-055-5056	250-A-160-C	481-1-43	20
JENS	PRIC	15828A	-J	F-16 MLG	WHEEL	1630-01-030-9239	5003062	481-7-1363	20
JENS	COOP	15834A		F-16 MLG	PIN ASSY	1620-01-071-0536	2006004-103	481-109-3	0
MART	SHEL	15849A		MULTIPLE	AIR FOIL MXU02A/B	1325-00-162-0244	609890-2	11K1-9-3	20
COOP	COOP	15862A		F-16 MLG	PISTON ASSY	1620-01-071-0538	2006602-103	482-00-3	35
COOP	POLL	15865A		C-141 MLG	FORWARD LINK	1620-00-927-2601	3610013-111	481-73-3	21
COOP	COOP	15866A		C-141 MLG	STRUT ASSY H/W	1630-01-103-7747	729965-10	481-07-23	22
DELE		15874A	-G-J	A-37 MLG	BRAKE HOUSING	1630-01-124-2873	10 OCT 88	481-2-1023	20
COOP	COOP	15984A		F-111 MLG	PIN SHOCK STRUT	1620-00-400-1007	12L9519-5	444-15-3	30
JENS	POLL	15998A		C-130 MLG	STRUT ASSY	1620-01-146-5708	7926623-10	482-23-3	65
MONR	ANDE	16019A	-J	F-4 MLG	STRUT ASSY	1620-01-024-8844	53-45400-301	482-57-3	69
MART	SHEL	16039A		F-16	ECM ADAPTER	1560-01-142-6594MF	16S601-819	16N6-35-3-2	15
MART	SHEL	16099A		MULTIPLE	LAU-100 LANCER R/H AIM 9	1440-01-104-0360AB	7839472-60	11L1-3-11	20
PARK	ANDE	16101A		LEM-30	T.E. ACTUATOR	1450-00-009-0946AH	67329921-10	3503-11-25-13	20
JENS	POLL	16123A	-G-J	C-130	BALLSCREW	1620-00-677-6681	1650E412	1663-2-40-23	20
JENS	RIGB	16136A		E-3A MLG	BRAKE TORQUE TUBE	1630-01-034-5387	9542482	481-2-1153	13
MART	SHEL	16148A		F-4	CENTERLINE ADAPTER ASSY	1095-00-192-5341BF	53-73023-321	1F40-3-1-4	00
MART	SHEL	16228A		MULTIPLE	AIRFOIL MXU 602	1325-00-491-0006	609890-1	11K1-9-3	05
MART	SHEL	16229A		MULTIPLE	AIRFOIL MXU 600	1325-00-491-0007	700924-1	11K1-9-3	10
JENS	POLL	16264A		KC-135 MLG	BRAKE COLLAR	1620-00-670-6602	69-1172-1	444-12-23	45
JENS	PRIC	16266A	-G-J	F-4 MLG	WHEEL	1630-00-730-0126	3-1185	483-7-1103	19
JENS	PRIC	16267A	-G-J	F-4 MLG	WHEEL	1630-00-052-1032	200AL23	483-7-1103	20

# F-4 NOSE WHEEL



# F-4 NOSE WHEEL PROCESS FLOW

PCN 16267A

WCD 01156N  
WHEEL ASSY

IN INDUCT

WCD 01155N  
INBOARD HALF

5 SPLIT WHEEL

WCD 01150N  
OUTBOARD HAL

5A DISASSEMBLE KEYS,  
CHILLS, WEIGHTS, ETC.

5A DISASSEMBLE KEYS,  
CHILLS, WEIGHTS, ETC.

6 HEAT TO 150°F -  
REMOVE BEARING CUP  
& STAMP WCD

6 HEAT TO 150°F -  
REMOVE BEARING CUP  
& STAMP WCD

7 LOAD ON OVERHEAD  
CONVEYER

7 LOAD ON OVERHEAD  
CONVEYER

7A CHEMICAL CLEAN

7A CHEMICAL CLEAN

7B UNLOAD FROM  
OVERHEAD CONVEYER

7B UNLOAD FROM  
OVERHEAD CONVEYER

9 BLAST CLEAN

9 BLAST CLEAN

10 REMOVE BEARING  
BORE BUSHING

10 REMOVE BEARING  
BORE BUSHING

11 BLAST CLEAN BORE

11 BLAST CLEAN BORE

12 LOAD ON OVERHEAD  
CONVEYER

12 LOAD ON OVERHEAD  
CONVEYER

12A STRIP ANODIZE



12A STRIP ANODIZE



↓

15 PENETRANT INSPECT

17 UNLOAD FROM  
OVERHEAD CONVEYER

19 NICK & BURR GRIND

30 EVALUATE & INSPECT-  
DELTA STAMP WCD  
AS REQUIRED

45 BEARING BORE  
REPAIR

50 TIE BOLT FACE  
REPAIR

65 MOVE TO BLDG #505

70-70K SULFURIC ANODIZE

72 MOVE TO BLDG #507

75 INSTALL BEARING CUP

80 MACHINE BUSHING & CUP

85 INSTALL BAFFLE, CUP,  
& BUSHING

90 VISUAL INSPECT &  
LOAD OVEN

95 HEAT TO 230° F

95A UNLOAD OVEN &  
INSTALL BEARING  
RACE

↓

↓

15 PENETRANT INSPECT

17 UNLOAD FROM  
OVERHEAD CONVEYER

19 NICK & BURR GRIND

30 EVALUATE & INSPECT  
DELTA STAMP WCD  
AS REQUIRED

45 BEARING BORE  
REPAIR

50 TIE BOLT FACE  
REPAIR

60 VALVE STEM  
HOLE REPAIR

65 MOVE TO BLDG #505

70-70K SULFURIC ANODIZE

72 MOVE TO BLDG #507

75 INSTALL BEARING CUP

80 MACHINE BUSHING & CUP

85 INSTALL BAFFLE, CUP,  
& BUSHING

90 VISUAL INSPECT &  
LOAD OVEN

95 HEAT TO 230° F

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100 LOAD ON OVERHEAD  
CONVEYER

100A WASH

100B PRIMER SPRAY

100C AIR DRY

100D MASK

100E PAINT 1<sup>ST</sup> COAT

100F PAINT 2<sup>ND</sup> COAT

100G AIR DRY

100H STRIP MASKING

100I UNLOAD FROM  
OVERHEAD CONVEYER

120 INSTALL SEALS &  
RETAINERS -  
BUY-OFF WCD -  
FINAL VISUAL INSPECT

↓

95A UNLOAD OVEN &  
INSTALL BEARING RACE

100 LOAD ON OVERHEAD  
CONVEYER

100A WASH

100B PRIMER SPRAY

100C AIR DRY

100D MASK

100E PAINT 1<sup>ST</sup> COAT

100F PAINT 2<sup>ND</sup> COAT

100G AIR DRY

100H STRIP MASKING

100I UNLOAD FROM  
OVERHEAD CONVEYER

120 INSTALL SEALS &  
RETAINERS  
BUY-OFF WCD -  
FINAL VISUAL INSPECT

WCD 01156N  
WHEEL ASSY

10 MATCH-UP

15 ASSEMBLE WHEEL  
HALVES TOGETHER



20 TOUCH-UP PAINT  
997 VERIFY WCD COMPLETENESS  
998 FINAL VISUAL INSPECT  
9999 SELL

# WORK CONTROL DOCUMENT (MEDS)

1 DATE 28027

1  
PAGE OF PAGES -

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
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13 SERIAL NUMBER	14 NOUN	16267A
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15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
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		GOVERNMENT DIRECTIVES: GROUP 68-04 HARDI 68-08 ALL PERSONNEL INVOLVED IN THE WORK SHOULD BE ADVISED OF THE DANGERS WHICH BECOME IN THE ONLY TRAINING AND FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE WORK. THE WORK SHOULD BE PERFORMED IN A SAFE MANNER. THE WORK SHOULD BE COMPLETED IN A SAFE MANNER. THE WORK SHOULD ALWAYS BE USED IN CONJUNCTION WITH THE WORK.			
		PERSONNEL WILL BE ONLY CLEARED AND ADVISED OF THE WORK DURING OPERATIONS/DISPATCH WORK.			
		WORK SHOULD BE A R N I N G MANY OF THE FOLLOWING REPAIR PROCEDURES SHOULD BE USED			
		EQUIPMENT. PROCEED WITH CARE WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFETY JARBS AND PRECAUTIONS SHOULD BE TAKEN TO PRECLUDE INJURIES.			
		PROCEED CAUTIONS: DISCONTINUE IN THE WORK. THE WORK SHOULD BE COMPLETED.			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	

## 01154N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89237

2 2  
PAGE OF PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
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10 MODEL DESIGN SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL HALF	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	001	DISPATCH			
	002	WHEEL HALF SUBASSY (0.8.)			
	003	WHEEL HALF SUBASSY (1.2.)			
	004	WHEEL HALF SUBASSY (1.5.)			
	005	WHEEL HALF SUBASSY (1.8.)			
	006	WHEEL HALF SUBASSY (2.1.)			
	007	WHEEL HALF SUBASSY (2.4.)			
	008	WHEEL HALF SUBASSY (2.7.)			
	009	WHEEL HALF SUBASSY (3.0.)			
	010	WHEEL HALF SUBASSY (3.3.)			
	011	WHEEL HALF SUBASSY (3.6.)			
	012	WHEEL HALF SUBASSY (3.9.)			
	013	WHEEL HALF SUBASSY (4.2.)			
	014	WHEEL HALF SUBASSY (4.5.)			
	015	WHEEL HALF SUBASSY (4.8.)			
	016	WHEEL HALF SUBASSY (5.1.)			
	017	WHEEL HALF SUBASSY (5.4.)			
	018	WHEEL HALF SUBASSY (5.7.)			
	019	WHEEL HALF SUBASSY (6.0.)			
	020	WHEEL HALF SUBASSY (6.3.)			
	021	WHEEL HALF SUBASSY (6.6.)			
	022	WHEEL HALF SUBASSY (6.9.)			
	023	WHEEL HALF SUBASSY (7.2.)			
	024	WHEEL HALF SUBASSY (7.5.)			
	025	WHEEL HALF SUBASSY (7.8.)			
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	027	WHEEL HALF SUBASSY (8.4.)			
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	037	WHEEL HALF SUBASSY (11.4.)			
	038	WHEEL HALF SUBASSY (11.7.)			
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	048	WHEEL HALF SUBASSY (14.7.)			
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	109	WHEEL HALF SUBASSY (33.0.)			
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	129	WHEEL HALF SUBASSY (39.0.)			
	130	WHEEL HALF SUBASSY (39.3.)			
	131	WHEEL HALF SUBASSY (39.6.)			
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	137	WHEEL HALF SUBASSY (41.4.)			
	138	WHEEL HALF SUBASSY (41.7.)			
	139	WHEEL HALF SUBASSY (42.0.)			
	140	WHEEL HALF SUBASSY (42.3.)			
	141	WHEEL HALF SUBASSY (42.6.)			
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	151	WHEEL HALF SUBASSY (45.6.)			
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	161	WHEEL HALF SUBASSY (48.6.)			
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	164	WHEEL HALF SUBASSY (49.5.)			
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	167	WHEEL HALF SUBASSY (50.4.)			
	168	WHEEL HALF SUBASSY (50.7.)			
	169	WHEEL HALF SUBASSY (51.0.)			
	170	WHEEL HALF SUBASSY (51.3.)			
	171	WHEEL HALF SUBASSY (51.6.)			
	172	WHEEL HALF SUBASSY (51.9.)			
	173	WHEEL HALF SUBASSY (52.2.)			
	174	WHEEL HALF SUBASSY (52.5.)			
	175	WHEEL HALF SUBASSY (52.8.)			
	176	WHEEL HALF SUBASSY (53.1.)			
	177	WHEEL HALF SUBASSY (53.4.)			
	178	WHEEL HALF SUBASSY (53.7.)			
	179	WHEEL HALF SUBASSY (54.0.)			
	180	WHEEL HALF SUBASSY (54.3.)			
	181	WHEEL HALF SUBASSY (54.6.)			
	182	WHEEL HALF SUBASSY (54.9.)			
	183	WHEEL HALF SUBASSY (55.2.)			
	184	WHEEL HALF SUBASSY (55.5.)			
	185	WHEEL HALF SUBASSY (55.8.)			
	186	WHEEL HALF SUBASSY (56.1.)			
	187	WHEEL HALF SUBASSY (56.4.)			
	188	WHEEL HALF SUBASSY (56.7.)			
	189	WHEEL HALF SUBASSY (57.0.)			
	190	WHEEL HALF SUBASSY (57.3.)			
	191	WHEEL HALF SUBASSY (57.6.)			
	192	WHEEL HALF SUBASSY (57.9.)			
	193	WHEEL HALF SUBASSY (58.2.)			
	194	WHEEL HALF SUBASSY (58.5.)			
	195	WHEEL HALF SUBASSY (58.8.)			
	196	WHEEL HALF SUBASSY (59.1.)			
	197	WHEEL HALF SUBASSY (59.4.)			
	198	WHEEL HALF SUBASSY (59.7.)			
	199	WHEEL HALF SUBASSY (60.0.)			
	200	WHEEL HALF SUBASSY (60.3.)			
	201	WHEEL HALF SUBASSY (60.6.)			
	202	WHEEL HALF SUBASSY (60.9.)			
	203	WHEEL HALF SUBASSY (61.2.)			
	204	WHEEL HALF SUBASSY (61.5.)			
	205	WHEEL HALF SUBASSY (61.8.)			
	206	WHEEL HALF SUBASSY (62.1.)			
	207	WHEEL HALF SUBASSY (62.4.)			
	208	WHEEL HALF SUBASSY (62.7.)			
	209	WHEEL HALF SUBASSY (63.0.)			
	210	WHEEL HALF SUBASSY (63.3.)			
	211	WHEEL HALF SUBASSY (63.6.)			
	212	WHEEL HALF SUBASSY (63.9.)			
	213	WHEEL HALF SUBASSY (64.2.)			
	214	WHEEL HALF SUBASSY (64.5.)			
	215	WHEEL HALF SUBASSY (64.8.)			
	216	WHEEL HALF SUBASSY (65.1.)			
	217	WHEEL HALF SUBASSY (65.4.)			
	218	WHEEL HALF SUBASSY (65.7.)			
	219	WHEEL HALF SUBASSY (66.0.)			
	220	WHEEL HALF SUBASSY (66.3.)			
	221	W			

# CLISON WORK CONTROL DOCUMENT (MEDS)

1 DATE 89278

1 PAGE OF PAGES

2 JOB ORDER NO 102778	3 QUANTITY	4 PRODUCTION SEC/RCC M0206	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER 2200 183	8 TECH DATA 400-1-01 MIL-STD-6808	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES 1-4 1035E	11 STOCK NUMBER 100 01 01 01 01 01	12 OPTIONAL <b>16267A</b>
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13 SERIAL NUMBER	14 NOUN UNREEL FAL NO. 1001 01 1004 01
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DEVELOPING DISCREPANCIES: APLK 66-8 MAN01 66-8 FPI 140 MIL-STD-6808 AN00075 YEM 66-4-8605			
		*****2014-78 ALUMINUM***** ALL PERSONNEL EMPLOYED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PROCEDURES AND WORKING CONDITIONS IN THE WORK AREA.			
		THE WORK IS BEING DONE IN ACCORDANCE WITH THE PROCEDURES REFERENCED IN BLOCK 10 OF THIS AFLO FORM 958. THE APPLICABLE SAFETY AND SUPERVISORY INSTRUCTIONS WILL BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		COMPONENTS WILL BE THOROUGHLY INSPECTED AND TESTED TO MEET THE REQUIREMENTS OF THE STATEMENT.			
		*****			
		ANY OF THE FOLLOWING PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, MATERIALS, WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE DRESSINGS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		THEORY (HANDOUT) (SEE COLUMN 16 IS EQUIVALENT TO DELTA STAMP).			
	001	2200 183			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	

## 01150N WORK CONTROL DOCUMENT (MEDS)

1 DATE 08278

PAGE 1 OF 1 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34D	005 *REQD*	BLAST CLEAN		001 01 002 02 003 03	
34D	006 *REQD*	REMOVE DUP FOOT WHEEL HALF		001 01 002 02 003 03	
34C	007 *REQD*	CHEN CLEAN		001 01 002 02 003 03	
34B	009 *REQD*	BLAST CLEAN		001 01 002 02 003 03	
34B	010 *REQD*	REMOVE BEARING BORE BUSHING		001 01 002 02 003 03	
34B	011 *REQD*	BLAST BEARING BORE WHEEL		001 01 002 02 003 03	
34C	012 *REQD*	AMULINE STRIP		001 01 002 02 003 03	
				001 01 002 02 003 03	
34E	019 *REQD*	MILK & BURK		001 01 002 02 003 03	
34E	030 *REQD*	F & I LAW TABLE 2.6707 MIN 2.6721 MAX		001 01 002 02 003 03	

1. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	01150N
		B	D	

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01155N WORK CONTROL DOCUMENT (MEDS)

1 DATE 8-2-78

PAGE 1 OF 20 PAGES

2. JOB ORDER NO 16267A		3. QUANTITY		4. PRODUCTION SEC/RCC NNDEN		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER 220A082				8. TECH DATA 30-1-51 30-1-51-1A7				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES F-4 NOSE		11. STOCK NUMBER 16267A			12. OPTIONAL 16267A				
13. SERIAL NUMBER		14. NOUN WHEEL DRIVE SYSTEM 1.0000							
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		ALL WORKING DIRECTIVES: BLOCK 30-51 BLOCK 30-51 1A7 MIL-STD-8836 1A7 MIL-A-8836							
		BLOCK 2014-T6 ALUMINUM							
		ALL PERSONNEL INVOLVED IN THE WORK SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRECAUTIONS AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND P.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFIC FORM 958. THE APPLIC- APPLICABLE SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. ALL WORKERS WILL BE THOROUGHLY TRAINED AND ADVISED OF (1) WORKER'S MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. "WARNING" PART OF THE FOLLOWING REPAIR PROCESSES REQUIRE THE USE OF THE FOLLOWING PROCESSES & OPERATIONS AND MUST BE COMPLETED IN THE FOLLOWING ORDER: 1. DISASSEMBLY 2. INSPECTION 3. REPAIR 4. REASSEMBLY 5. TESTING 6. CLEANING 7. PAINTING 8. FINISHING 9. INSPECTION 10. PACKAGING 11. SHIPPING							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/EN			
DISPATCH	FUNCTIONAL CODE	A		C		01155N			
		B		D					

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## 01155N WORK CONTROL DOCUMENT (MEDS)

1 DATE 03298

PAGE 2 OF 2 PAGES

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN SHELL HALF SUBASSEMBLY IN BOARD						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAND.							
	001	DISASSEMBLE							
34D	005	DISASSEMBLE							
	*REQD*								
34D	006	REMOVE OUP FROM WHEEL							
	*REQD*								
34C	007	OUP CLEAN							
	*REQD*								
34B	009	OUP CLEAN							
	*REQD*								
69	010	REMOVE BEARING BURE BEARING							
	.29								
34B	011	BURE BEARING BURE BEARING							
	.01								
34C	012	REMOVAL STRIP							
	*REQD*								
34B	015	REMOVAL STRIP							
	*REQD*								
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		01155N			
		B		D					

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN WHEEL ROLF LUBRICANT 1 1/2						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
34E	019 *REDD*	NICK & BURK LUBRICATION					001 7000 002 04 003 RD06		
34E	030 *REDD*	E & I IAW TABLE 11 BEARING BORE 3.1327 MIN 3.1343 MAX *O/P MOVE*					001 7000 002 04 003 E102		
69	045 .79	BEARING BORE O.S. INNER IAW FIG 1 *O/P MOVE*					001 7000 002 01 003 L012		
69	050 .01	TIE BOLT FACE REPAIR IAW FIG 2 *O/P MOVE*					001 7000 002 01 003 D912		
	070 *REDD*	ANODIZE TYPE II CLASS 1 *O/P MOVE*					001 7000 002 00 003 AS10		
69	075 .39	INSTALL CUP INTO BEARING BORE BUSHING P/N L305610 P/N 2006601					001 7000 002 01 003 BE01		
69	080 .93	MACHINE O.D. OF BUSHING AND CUP ASSEMBLY P/N N.P.L.					001 7000 002 01 003 LE07		
69	085 .93	INSTALL GREASE BAFFLE AND LUBRICANT CUP ASSY P/N 2204204 P/N N.P.L.					001 7000 002 01 003 BE01		
69	090 *REDD*	PRE-FINAL INSPECTION AND ASSEMBLY *O/P MOVE*					001 7000 002 07 003 7015		
	095 1.0	BAFFLE AND ROLL INSIDE FIG 3 *O/P MOVE*					001 7000 002 07 003 7015		

22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN	
FINAL DESTINATION	DISPATCH	FUNCTIONAL CODE	DISPATCH

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2. JOB ORDER NO 16207A		3. QUANTITY <i>1ea</i>		4. PRODUCTION SEC RCC MNPGW		5. DATE SCHED		6. DATE COMPLETED APR 24 1988	
7. PART NUMBER 220A123				8. TECH DATA 4W-1-61 4W3-7-1143				9. ITEM SERIAL NO 7987	
10. MODEL/DESIGN SERIES F-4 NCSE			11. STOCK NUMBER 1630008521432			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN WHEEL ASSY			15. MECHANIC			
15. DISPATCH STATION		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED				18. MECHANIC	
				GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.					
				*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.					
				*****WARNING***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.					
				*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.					
		001		220A123					
13		010		*MATCH-UP* ROUTED COMPONENTS (CONTINUED)				M 71152	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN					
DISPATCH		FUNCTIONAL CODE		A. <i>Tom Nelson</i> MANEL 3 NOV 88				01156N	
				B. <i>Colin</i> BNOVOS MANSM 9 NOV 88					
				C. <i>James</i> JANOVOS 9 NOV 88					

## 01156N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88237

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN WHEEL ASSY					
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
		NEW/SERVICEABLE REWORK NO REWORK WHEEL HALF SUBASSY (O.B.) 01150N WHEEL HALF SUBASSY (I.B.) 01155N							
13	015 *REQD*	ASSEMBLE *C/P MOVE*  APR 21 1988					10/01 71152		
13	020 *REQD*	FINAL TOUCH UP PAINT *C/P MOVE* 11 APR 1988					M		
13	997 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					M		
13	998 *REQD*	FINAL PRODUCT VISUAL INSPECTION					M		
		COORDINATED BY: PLANNING/WK MEASURE: TOM WIXOM SCHEDULING: JIM COLVIN PRODUCTION: ROGER MURRY QUALITY: ED OVERDIEK							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		01156N			
		B		D					

01150N WORK CONTROL DOCUMENT (MEDS)					1 DATE 8611E	PAGE 1 OF 1 PAGES	
2 JOB ORDER NO 16287A 84A		3 QUANTITY IEA		4 PRODUCTION SEC REC MNP GW		5 DATE SCHED OCT 11 1988	
7 PART NUMBER 220A283			8 TECH DATA 4W-1-61 4W3-7F1143			9 ITEM SERIAL NO 7987	
10 MODEL DESIGN SERIES F-4 NOSF		11 STOCK NUMBER 1632011532016		12 OPTIONAL DMMND			
13 SERIAL NUMBER E2802		14 NOUN WHEEL HALF OUTBOARD					
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED			18 MECHANIC	19 P	20 Q
		GOVERNING DIRECTIVES: AFMCP 66-51 MANOI 66-3 EPI IAW MIL-STD-8836 ANODIZE IAW MIL-A-8625					
		*****2014-T6 ALUMINUM*****					
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 9 OF THIS AFMCP FORM 956. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.					
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/ DISPATCH STATIONS.					
		"WARNING" MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.					
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.					
34L	001	DISASSEMBLE					
		*REQD* *C/P MOVE					
21 FINAL DESTINATION DISPATCH		22 COORDINATION/INITIATING RCC SIGNATURE/DATE A		23 DOCUMENT/SN 21150N			
		B					
		C					
		D					

## 21150N WORK CONTROL DOCUMENT (MEDS)

1 DATE

85119

PAGE 2 OF 2 PAGES

1 ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES		11 STOCK NUMBER				12 OPTIONAL			
13 SERIAL NUMBER		14 NOVIN WHEEL HALF OUTPCARD							
15 DISPATCH STATION	16 PER REC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
34C	203	CLEAN AS REQ'D *REQD* *C/P MOVE				M 71376 12 OCT 1988	N 71375		
69	205	REMOVE BEARING BORE PUSHING *C/P MOVE*							
34C	207	ELAST BEARING BORE AREA *C/P MOVE*					M		
34	212	FPI *C/P MOVE *REQD*				M/C 12 OCT 1988			
34	222	NICK & PUPP *C/P MOVE *REQD*				M 71307 12 OCT 1988			
34	232	E & I IAW TABLE II BEARING BORE 2.8727 MIN 2.8721 MAX *C/P MOVE *REQD*				OCT 14 1988			
69	245	BEARING BORE O.S. OUTER IAW FIG 1 *C/P MOVE							
69	252	TIE FLT FACE REPAIR IAW FIG 2 *C/P MOVE					M		
69	260	C.S. VALVE STEM BORE & RE-IDENTIFY IAW FIG 3 *C/P MOVE					M		
26	270	ANODIZE TYPE II CLASS I *C/P MOVE *REQD*				15 OCT 1988			
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21150N			
		B		D					



## 01150N WORK CONTROL DOCUMENT (MEDS)

1 DATE

86118

PAGE 3 OF 3 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES		11 STOCK NUMBER				12 OPTIONAL			
13 SERIAL NUMBER		14 NOUN WHEEL HALF OUTBOARD							
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
69	075	INSTALL PUSHING & BEARING CUP *C/P MOVE					M		
13	080 *REQD*	OK TO ASSEMBLE *C/P MOVE							
13	090 *REQD*	PAINT *C/P MOVE							
13	120 *REQD*	BALANCE *C/P MOVE							
13	122	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958							
13	132	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE							
		COORDINATED BY: PLANNING: LARRY PRICE WK MEASURE: KERRY COOP SCHEDULING: SUE WARD							
		PRODUCTION: ROGER MURRAY							
		QUALITY: ED OVERDIEK							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		01150N			
		B		D					

## 01155N WORK CONTROL DOCUMENT (MEDS)

DATE

88111

PAGE 1 OF 1 PAGES

2 JOB ORDER NO 16267A 84A		3 QUANTITY IEA		4 PRODUCTION SEC/RCC MMPGW		5 DATE SCHED OCT 11 1983		6 DATE COMPLETED	
7 PART NUMBER 220A282				8 TECH DATA 4W-1-61 4W3-7-1143				9 ITEM SERIAL NO 7987	
10 MODEL DESIGN SERIES F-4 NOSE			11 STOCK NUMBER 1630211611591			12 OPTIONAL S/WND			
13 SERIAL NUMBER E-2 881			14 NOUN WHEEL HALF INBOARD						
15 DISPATCH STATION		16 PERF RCC/OP NO		17 WORK TO BE ACCOMPLISHED				18 MECHANIC	
				GOVERNING DIRECTIVES: AFLCR 66-51 MANCI 66-3 FPI IAW MIL-STD-6866 ANODIZE IAW MIL-A-8625					
				*****2014-T6 ALUMINUM*****					
				ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.					
				*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.					
				"WARNING"					
				MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.					
				*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.					
34D		001		DISASSEMBLE					
		*REQD*		*C/P MOVE				OCT 11 1983	
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN					
DISPATCH		FUNCTIONAL CODE		A		C		01155N	
				B		D			

## 01155N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88111

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF INBOARD						
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 O	
34C	003	CLEAN AS REQ'D *REQD* *C/P MOVE				M 71376	M 71376		
69	005	REMOVE BEARING BORE BUSHING *C/P MOVE*				12 OCT 1988			
34C	007	BLAST BEARING BORE AREA *C/P MOVE*					M		
34	010	FPI *C/P MOVE *REQD*				M 71307	M 71307		
34	020	NICK & BURR *C/P MOVE *REQD*				14 OCT 1988			
34	030	E & I IAW TABLE II BEARING BORE 3.1827 MIN 3.1843 MAX *REQD* *C/P MOVE				15 OCT 1988			
69	045	BEARING BORE O.S. INNER IAW FIG 1 *C/P MOVE							
69	050	TIE BOLT FACE REPAIR IAW FIG 2 *C/P MOVE					M		
26	070	ANODIZE TYPE II CLASS I *C/P MOVE *REQD*				15 OCT 1988			
69	075	INSTALL BUSHING & BEARING CUP *C/P MOVE					M		
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		01155N			
		B		D					

## 01155N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88111

PAGE 3 OF 3 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOLN WHEEL HALF INBOARD							
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19	20	
13	080 *REQD*	OK TO ASSEMBLE *C/P MOVE 30 OCT 1988					M 71174		
13	090 *REQD*	PAINT *C/P MOVE 21 OCT 1988				70725			
13	100 *REQD*	BALANCE *C/P MOVE 70725							
13	120 WOC 25	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					M 71152		
13	130 WOC 25	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE AF 23					M 71152		
		COORDINATED BY: PLANNING: LARRY PRICE WK MEASURE: KERRY COOP SCHEDULING: SUE WARD							
		PRODUCTION: ROGER MURRAY							
		QUALITY: ED OVERDIEK							
1 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		01155N			
		B		D					

# NAME: MEL ANDERSON

ALC: 00

PCN: 16267A

RCC: WHEELS

WCD: 01155N

WCD DATE: 88298

OP #	RCC	OP DESC	OP FAC	OP OCCU	OP TYPE	OP MAND	FLOW HRS	SKIL CODE	QTY	TIME %	REQ HRS	EQUIP CODE	QTY	TIME %	REQ HRS
005A	MANPGW	D1S	1.00	P				HB09	1	0.10	0.10	PM0921	1	0.10	0.10
006	MANPGW	REMY	1.00	P				HB09	1	0.02	0.02	PM0423	1	0.02	0.02
006	MANPGW	REMY	1.00	P								PM0426	1	0.03	0.03
007	MANPGW	LOAD	1.00	T								PM0921	1	0.02	0.02
007	MANPGW	LOAD	1.00	P				HB09	1	0.02	0.02	PM0901	1	0.02	0.02
007A	MANPGW	CLN	1.00	P				HB10	1	0.03	0.03	0901	1	1.50	1.50
007A	MANPGW	CLN	1.00	P				HB05	1	0.20	0.20	PM0634	1	1.50	1.50
007B	MANPGW	UNLD	1.00	P				K109	1	0.20	0.20	PM0901	1	0.20	0.20
009	MANPGW	BLS	1.00	P				JA07	1	0.06	0.06	PM7313	1	0.15	0.15
010	MANPRA	REMY	0.50	T				JA10	1	0.80	0.80	PM5197	1	0.80	0.80
010	MANPRA	REMY	0.50	S				JA10	1	0.79	0.79	PM5197	1	0.79	0.79
010	MANPRA	REMY	0.50	P				JA10	1	0.10	0.10	FL0002	1	0.10	0.10
011	MANPGW	BLST	0.50	T				UVHD	1	0.05	0.05	PM0416	1	0.05	0.05
011	MANPGW	BLST	0.50	P				K109	1	0.03	0.03	PM0901	1	0.03	0.03
012	MANPGW	LOAD	1.00	P				HB05	1	0.25	0.25	PM0901	1	0.33	0.33
012A	MANPGW	STRP	1.00	P				HB05	1	0.25	0.25	PM0901	1	0.33	0.33
012A	MANPGW	STRP	1.00	P								PM0609	1	0.33	0.33
015	MANPNA	FPI	0.75	T								PM0901	1	0.02	0.02
015	MANPNA	FPI	0.75	P				DB09	2	0.05	0.05	PM0901	1	1.05	1.05
015	MANPNA	FPI	0.25	T								PM0679E	1	1.05	1.05
015A	MANPNA	FPI	0.25	T								PM0901	1	0.02	0.02
015A	MANPNA	FPI	0.25	P				DB09	1	0.10	0.10	PM0901	1	1.05	1.05
015A	MANPNA	FPI	0.25	P								PM0679E	1	1.05	1.05
017	MANPGW	UNLD	1.00	T								PM0901	1	0.03	0.03
017	MANPGW	UNLD	1.00	P				DI07	1	0.04	0.04	PM0901	1	0.04	0.04
019	MANPGW	BURR	1.00	T								PM0911	1	0.03	0.03
019	MANPGW	BURR	1.00	P				DI05	1	0.20	0.20	PM0005	1	0.20	0.20
030	MANPGW	INSP	1.00	P				DI09	1	0.04	0.04	PM0911	1	0.04	0.04
045	MANPRA	REPR	0.25	T				JA10	1	0.02	0.02				
045	MANPRA	REPR	0.25	S				JA10	1	0.17	0.17	PM7211	1	0.17	0.17
045	MANPRA	REPR	0.25	P				JA10	1	0.51	0.51	PM7211	1	0.51	0.51
050	MANPRA	REPR	0.05	T				JA10	1	0.02	0.02				
050	MANPRA	REPR	0.05	S				JA10	1	0.56	0.56	PM2577	1	0.56	0.56
050	MANPRA	REPR	1.00	P				JA10	1	0.62	0.62	PM2577	1	0.62	0.62
065	MANOUHD	MOVE	1.00	T								FL0002	1	0.10	0.10
070	MANPRC	ANZZ	1.00	T				UP05	1	0.05	0.05	PM4118	1	0.05	0.05
070	MANPRC	ANZZ	1.00	S				UP09	1	0.01	0.01	PM5681	1	0.01	0.01
070	MANPRC	ANZZ	1.00	S								CE20	1	0.01	0.01
070	MANPRC	ANZZ	1.00	S								PM5681	1	0.08	0.08
070	MANPRC	ANZZ	1.00	P				UP09	1	0.05	0.05	CE20	1	0.08	0.08
070A	MANPRC	ANZZ	1.00	S				UP09	1	0.01	0.01	CE20	1	0.01	0.01
070A	MANPRC	ANZZ	1.00	P				UP09	1	0.01	0.01	CE20	1	0.01	0.01
070A	MANPRC	ANZZ	1.00	P				UP09	1	0.01	0.01	CE20	1	0.01	0.01
070A	MANPRC	ANZZ	1.00	P				UP09	1	0.01	0.01	PM5670	1	0.01	0.01
070B	MANPRC	ANZZ	1.00	S				UP09	1	0.01	0.01	CE20	1	0.01	0.01
070B	MANPRC	ANZZ	1.00	P				UP09	1	0.01	0.01	CE20	1	0.01	0.01
070B	MANPRC	ANZZ	1.00	P				UP09	1	0.01	0.01	CE20	1	0.01	0.01
070B	MANPRC	ANZZ	1.00	P				UP09	1	0.01	0.01	PM5693	1	0.01	0.01
070C	MANPRC	ANZZ	1.00	S				UP09	1	0.01	0.01	CE20	1	0.01	0.01
070C	MANPRC	ANZZ	1.00	P				UP09	1	0.01	0.01	CE20	1	0.01	0.01

070E MANPRC	ANZ2	1.00	P	UP09	PM5698	1	0.01
070F MANPRC	ANZ2	1.00	S	UP09	CE20	1	0.01
070F MANPRC	ANZ2	1.00	P	UP09	CE20	1	0.01
070F MANPRC	ANZ2	1.00	P	UP09	PM5717	1	0.58
0703 MANPRC	ANZ2	1.00	S	UP09	0	0	0.01
0703 MANPRC	ANZ2	1.00	P	UP09	1	1	0.01
0703 MANPRC	ANZ2	1.00	P	UP09	PM5702	1	0.01
0703 MANPRC	ANZ2	1.00	P	UP09	CE20	1	0.01
070H MANPRC	ANZ2	1.00	S	UP09	0.01	1	0.01
070H MANPRC	ANZ2	1.00	S	UP09	0.05	1	0.08
070H MANPRC	ANZ2	1.00	P	UP09	0.10	1	0.25
070H MANPRC	ANZ2	1.00	P	UP09	MIN	1	0.08
070H MANPRC	ANZ2	1.00	P	UP09	MAX	1	0.01
070H MANPRC	ANZ2	1.00	P	UP09	MIN	1	0.01
070I MANPRC	ANZ2	1.00	S	UP09	CE20	1	0.01
070I MANPRC	ANZ2	1.00	S	UP09	CE20	1	0.01
070I MANPRC	ANZ2	1.00	S	UP09	PM5700	1	0.01
070J MANPRC	ANZ2	1.00	S	UP09	0.01	1	0.01
070J MANPRC	ANZ2	1.00	P	UP09	0.01	1	0.01
070J MANPRC	ANZ2	1.00	P	UP09	CE20	1	0.01
070J MANPRC	ANZ2	1.00	P	UP09	PM5676	1	0.01
070K MANPRC	ANZ2	1.00	P	UP09	0.01	1	0.03
070K MANPRC	ANZ2	1.00	P	UP09	CE20	1	0.03
070K MANPRC	ANZ2	1.00	P	UP09	CE20	1	0.03
070K MANPRC	ANZ2	1.00	P	UP09	PM4118	1	0.10
072 MANOVHD	MOVE	1.00	T	UP05	0.10	1	0.50
075 MANPRA	INST	1.00	T	JA08	0.02	1	0.23
075 MANPRA	INST	1.00	S	JA08	0.08	1	0.50
075 MANPRA	INST	1.00	P	JA08	0.19	1	0.23
080 MANPRA	MACH	1.00	P	JA10	0.02	1	0.10
080 MANPRA	MACH	1.00	P	JA10	0.50	1	0.10
080 MANPRA	MACH	1.00	P	JA10	0.23	1	0.10
085 MANPRA	INST	1.00	T	JA09	0.02	1	3.00
085 MANPRA	INST	1.00	S	JA09	0.19	1	0.05
085 MANPRA	INST	1.00	P	JA09	0.08	1	0.01
085 MANPRA	INST	1.00	P	JA09	0.10	1	0.01
090 MANPGP	LOAD	1.00	P	YH09	FL0001	1	0.01
090 MANPGP	LOAD	1.00	P	YH09	PM0931	1	0.01
095 MANPGR	HEAT	1.00	P	YH09	PM0435	1	0.02
095 MANPGR	HEAT	1.00	P	YH09	PM0936	1	0.02
095 MANPGR	INST	1.00	P	YH09	PM0922	1	0.01
095 MANPGR	UNLD	1.00	P	YH09	PM0436	1	0.01
100 MANPGP	LOAD	1.00	P	3509	PM0438	1	0.02
100 MANPGP	WASH	1.00	P	3509	PM0922	1	0.02
100A MANPGP	WASH	1.00	P	3509	PM0922	1	1.00
100A MANPGP	PRIM	1.00	S	3509	PM0922	1	0.02
100B MANPGP	PRIM	1.00	P	3509	PM0922	1	0.02
100C MANPGP	DRY	1.00	P	3509	PM0922	1	0.02
100D MANPGP	MASK	1.00	P	3509	PM0922	1	0.02
100E MANPGP	PNT1	1.00	S	3509	PM0922	1	0.02
100F MANPGP	PNT2	1.00	S	3509	PM0922	1	0.02
100F MANPGP	PNT2	1.00	P	3509	PM0922	1	0.02
100G MANPGP	DRY	1.00	P	3509	PM0922	1	0.50
100H MANPGP	STRP	1.00	P	YH09	PM0922	1	0.03
100I MANPGP	UNLD	1.00	P	YH09	PM0959	1	0.10
120 MANPGP	INST	1.00	P	YH09	WA0004	1	0.10
					PM0940	1	0.10

FOR S S W F P A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	STOR	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	FFD TIME	STD HOURS	A DLY PCT C
001	S	E	HB	EA 5	J 88301	1.00	PERCENT ENGR 99.9	DISASSY F4 NOSE WHEEL	.48		.48	
0001		HB	01	00		.00		PART NUMBER/NSN	.000	.000	.000	0
0010					220A123			1630011532016				
0005		HB	01	25		1.00		DISASSEMBLE WHEEL SM	.160	.040	.201	42
0010	E			RWB-DW-11	1.00		DIS SM WHL (TIE BOLT TYPE)		.09806		.122	
0020	E			RWB-DW-71	5.00		REM UNDESTR WHL TIE BOLT	10 TIE BOLTS	.01056		.066	
0110	E			RJP-PW-R1	1.00		REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
0006		HB	01	25		1.00		REMOVE BEARING CUPS	.226	.057	.283	.3 58
0010	E			RWB-BC-01	1.00		REMOVE BEARING CUPS		.16346		.204	
0020	E			RWB-MH-02	.50		LOAD HOOK W/WHEELS F/CLEING		.10532		.065	
0030	E			RJP-PW-R1	1.00		REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
0000		HB	01	25		.01		LABOR STD HISTORY	.000	.000	.000	0
0010							07DEC84 2 YEAR REVIEW/UPGRADE TO ENG STD					
0011							<OLD STD> .25					
0020							06JUN85 CHANGED SKL CODE NO TM CHNG					
0030							26JUN85 ADDED NICK&BURR TM (TM WAS .20 )					
0900							D.FARKER TECHN PANCAA					

2 INTERROGATE LABOR STANDARDS. INPUT

REC NACP NR

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16267A F4 N WPL 220A123

RCC MNPGR

4W3-7-1143

81279

OPER TECH S S W F FF A/R REV

T K MR A FA SUPPORT DCC

STEP D L K C DC ELEMENT FACT

DESCRIPTION

STORED

SUPPLEMENTAL

BASE

FFD

STD

A

HOURS

TIME

HOURS

DLY PCT C

0001	S	N	KI	EA	5	J	88101	1.00	PERCENT ENGR 46.7	CLEAN F4 NOSE WHEEL	.54		.54		
0001			KI	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0	
0010							220A123			1630011532016					
0007			KI	01	27			1.00		CHEM CLEAN WHEEL ALUM	.116	.031	.147	2.8	27
0010	N					ZLG-CL-M1		.50	LOAD & UNLOAD CARRIER CLEAN	.21200			.134		
0020	E					RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DCC	.01001			.012		
0009			KI	01	27			1.00		BLAST CLEAN WHEEL SM	.152	.041	.194		36
0010	E					RWB-CB-B1		1.00	BLAST SM PT OR BSKT V/SM PTS	.03668			.046		
0020	N					ZLG-CL-M1		.50	LOAD & UNLOAD CARRIER CLEAN	.21200			.134		
0030	E					RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DCC	.01001			.012		
0011			KI	01	27			.14		BLAST CLEAN WHEEL SM	.152	.006	.027		5
0010	E					RWB-CB-B1		1.00	BLAST SM PT OR BSKT V/SM PTS	.03668			.046		
0020	N					ZLG-CL-M1		.50	LOAD & UNLOAD CARRIER CLEAN	.21200			.134		
0030	E					RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DCC	.01001			.012		
0012			KI	01	27			1.00		ANODIZE STRIP WHEEL ALUM	.136	.037	.173	.7	32
0010	E					ZCD-ST-S1		1.00		ANODIZE STRIP	.12630			.160	
0030	E					RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DCC	.01001			.012		
9000			KI	01	27			.01		LABOR STD HISTORY	.000	.000	.000		0
0010									2 YEAR REVIEW/NO TIME CHANGE						
0020									18JUL85 MOVED N&B TO HB SKL (TM WAS .29)						
0900									D.PARKER TECHN MANEAA						

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NRCR NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS  
RCC MMFNA

02/01/89  
4W3-7-1143

A-E046B-MM1-DY-M45 PAGE 0001  
81279

16267A F4 N WHL 220A123

OPER TECH S S W F PF A/R REV

T K #R A FA SUPPORT

STEP D L K C DC ELEMENT

OCC

FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE  
HOURS

PF  
TIME

STD  
HOURS

A  
DLY PCT C

CHPNA	S	X	DB	EA	2	J 88301	1.00	PERCENT ENGR 99.9	NDI F4 NOSE WHEEL	.12		.12		
0015			DB	01	11		.13		NDI TIE BOLTS 1ST TIME	1.005	.014	.145	117	
0010	E					ZLG-ND-M6	11.00	MAGNAGLO INSP SMALL OBJECT		.09138		1.115		
0020			DB	01	11		.13		NDI DRIVE KEYS 1ST TIME	.822	.012	.119	96	
0010	E					ZLG-ND-M6	9.00	MAGNAGLO INSP SMALL OBJECT		.09138		.912		
2000			DB	01	00		.00		PART NUMBER/NSN	.000	.000	.000	0	
0010						220A282			1630011611591					
0020						220A283			1630011532016					
2001			DB	01	11		1.00		ZYGLO WHEEL SM	.099	.011	.110	.7	89
0010	E					ZLG-ND-Z1	2.00	ZYGLO INSP SMALL PART BLD507		.04466		.099		
0020	E					RJP-PW-R1	1.00	REM RPL PAPERWRK SIGN OFF DOC		.01001		.011		
9000			DB	01	00		1.00		LABOR STD HISTORY	.000	.000	.000	0	
0900								LLOYD A. HARGIS MANEL-1 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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16267A F4 N WHL 220A123  
ER TECH S S W F PF A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	STOR	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	FFD TIME	STD HOURS	A DLY PCT C
150	E	N	DI	EA 5	J 88301	1.00	PERCENT ENGR 17.5	E&I F4 NOSE WHEEL D/B	.35		.35	
0001		DI	01	00		1.00		PART NUMBER/NSN	.000	.000	.000	0
	0010						220A283	1630011532016				
0019		DI	01	27		1.00		NICK & BURR WHEEL SM/HALF	.125	.034	.159	45
	0010	E			RLS-RS-NC	1.00	NICK & BURR PTS-CONST F/PREP		.02312		.029	
	0020	N				1.00		NICK & BURR WHEEL SM/HALF	.09187		.116	
	0030	E			RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
0030		DI	01	15		1.00		E & I AND ROUTE WHEEL	.167	.025	.193	55
	0010	N				1.00		E&I AND ROUTE WHEEL HALF	.14919		.171	
	0020	E			RWS-CH-W2	1.00	REMV WHL HLF F/PAINT CONVDOR		.00833		.009	
	0030	E			RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000		DI	01	15		.01		LABOR STANDARD HISTORY	.000	.000	.000	0
	0010						07DEC84 2 YEAR REVIEW/NO TIME CHANGE					
	0900						N MCNRCE/MANEAA					

D INTERROGATE LABOR STANDARDS, INPUT

RCC FRD NRQP NR

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16267A F4 N WHL 220A123  
TECH S S W F FF A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	EASE HOURS	FFD TIME	STD HOURS	A DLY PCT C
E155	E	N	DI	EA 5	J 29301	1.00	PERCENT ENGR 17.5	E&I F4 NOSE WHEEL 1/8	.75		.75	
0001		DI	01	00		.00		PART NUMBER/NSN	.000	.000	.000	0
0010							220A282	1630011611591				
0019		DI	01	27		1.00		NICK & BURR WHEEL SM/HALF	.125	.024	.159	45
0010	E				RUG-RS-NC	1.00	NICK & BURR PTS-CONST F/PREP		.02312		.029	
0020	N					1.00		NICK & BURR WHEEL SM/HALF	.09187		.116	
0030	E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
0030		DI	01	15		1.00		E & I AND ROUTE WHEEL	.167	.025	.193	55
0010	N					1.00		E&I AND ROUTE WHEEL HALF	.14919		.171	
0020	F				RWB-CH-W2	1.00	REMV WHL HLF F/PAINT CONVYGR		.00833		.009	
0030	E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
9000		DI	01	15		.01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010							07DEC84 2 YEAR REVIEW/NO TIME CHANGE					
0900							N MONRCE/MANEAA					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRDP NR

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16267A WHEEL F4 NOSE

RCC MNPRA

4W3-7-1143

21279

ER TECH S S W P FF A/R REV

STEP	D L	K	U	OC	ELEMENT	FACT	GOC	STOR	DESCRIPTION	EASE HOURS	FFD TIME	STD HOURS	A DLY PCT C
155	S	E	JA	EA	1	J 88301	1.00	PERCENT ENGR 95.5	MACH WHL HALF SUBASSY F4N I.	1.07		1.07	
0001			JA	01	00		.00		PART NUMBER/NSN	.000	.000	.000	0
0010						220A292			1630011611591				
0010			JA	01	15		.50		REM BEARING BORE BUSH.MED.	.787	.059	.453	42
0010	E					RML-SU-V2	.25	S/U VERT MILL BORE LAG FIXTRPRORATE OVER 8 PARTS		.80157		.230	
0020	E					RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP	JIS BORE	.15776		.181	
0030	E					RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E					RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E					RML-BA-CD	1.00	BORE HOLE 2 X 2 GROUP 1	USE PROPER ELEMENT/TABLE	.21626		.248	
0060	E					RJP-FW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0045			JA	01	15		.25		BEARING BORE REP,PENSOTTI	.508	.019	.146	14
0010	M						1.00		SET UP PENSOTTI	.16700		.192	
0020	E						1.00	4	.26 MACHINE BEARING BORE	.29333		.337	
0030	E					RJP-FW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC/		.01001		.011	
0040	E					RPL-MH-P1	1.00	GET PALLET JACK & MOVE PARTS/		.03815		.043	
0050			JA	01	15		.05		SPOT FACE TIE BOLT HOLES	.524	.005	.036	3
0010	E					RDR-SU-R1	1.00	S/U TO O/S BOSSES RAD DRILL ,		.56378		.648	
0020	E					RML-HP-H1	1.00	PART ON/OFF MACH HAND NO RAP,		.03068		.035	
0030	E					KAL-SM-31	1.00	SPOT-FACE OR COUNTERBORE ,		.02004		.023	
0040	E					RJP-FW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC,		.01001		.011	
0075			JA	01	15		1.00		INST CUP INTO BUSHING	.077	.012	.089	8
0010	E					REW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020	E					REW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030	E					RJP-FW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0080			JA	01	15		1.00		MACH BEARING BORE BUSHING	.229	.034	.264	25
0010	E					RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 8 PARTS	.49962		.143	
0020	E					RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030	E					KML-TA-HC	1.00	DIA 4.00-5.00 REM .033-.250		.08497		.097	
0040	E					RJP-FW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0085			JA	01	15		1.00		INST BEARING BORE BUSH & CUP	.077	.012	.089	8
0010	E					REW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 8 PARTS	.18669		.053	
0020	E					REW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030	E					RJP-FW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
9000			JA	01	15		1.00		LABOR STANDARD HISTORY	.000	.000	.000	0
0900									C. W. RIGBY MANEL-1 73357				

O INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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16267A WHEEL F4 NOSE

RCC MNPRA

4W3-7-1143

81279

PER TECH S S A F FF A/R REV

STEP	J L	K C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	REF TIME	STD HOURS	A DLY FCT C
150	S	E	JA	EA 1	J	88301	1.00 PERCENT ENGR 96.7	MACH WHL HALF SUBASSY F4N	1.50		1.50	
0001			JA	01	00		.00	PART NUMBER/NSN	.000	.000	.000	0
0010						220A283		1630011532016				
0010			JA	01	15		.50	REM BEARING BORE BUSH, MED.	.787	.059	.450	10
0010 E						RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXT PRGRATE OVER 8 PARTS	.80167		.270	
0020 E						RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP JIG BORE	.15776		.181	
0030 E						RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12599		.146	
0040 E						RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07509		.087	
0050 E						RML-BA-CD	1.00	BORE HOLE 2 X 2 GROUP 1 USE PROPER ELEMENT/TABLE	.21526		.248	
0060 E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0045			JA	01	15		.25	BEARING BORE REP. PENSOTTI	.508	.019	.146	10
0010 N							1.00	SET UP PENSOTTI	.16700		.192	
0020 E							1.00	4 .26 MACHINE BEARING BORE	.29333		.337	
0030 E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC/	.01001		.011	
0040 E						RPL-MH-P1	1.00	GET PALLET JACK & MOVE PARTS/	.03815		.043	
0050			JA	01	15		.05	SPOT FACE TIE BOLT HOLES	.624	.005	.036	2
0010 E						RDR-SU-R1	1.00	S/U TO O/S BOSSES RAD DRILL	.56378		.648	
0020 E						RML-HP-H1	1.00	PART ON/OFF MACH HAND NO RAP	.03068		.035	
0030 E						KAL-SM-31	1.00	SPOT-FACE GR COUNTERBORE	.02004		.023	
0040 E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0060			JA	01	15		.80	VALVE STEM HOLE REP RAD DR	.459	.055	.423	28
0010 E						RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRGRATE OVER 8 PARTS	.56378		.162	
0020 E						RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL	.30463		.350	
0030 E						REW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.004	
0040 E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0075			JA	01	15		1.00	INST CUP INTO BUSHING	.077	.012	.089	6
0010 E						REW-BU-S1	.25	SET UP TO REBUSH BOSSES PRGRATE OVER 4 PARTS	.18669		.053	
0020 E						REW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062		.023	
0030 E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0080			JA	01	15		1.00	MACH BEARING BORE BUSHING	.229	.034	.264	18
0010 E						RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRGRATE OVER 8 PARTS	.49962		.143	
0020 E						RLA-HP-C1	1.00	1ST PART IN-GUT SCROLL CHUCK	.01001		.011	
0030 E						RML-TA-HC	1.00	DIA 4.00-5.00 REM .033-.250	.08497		.097	
0040 E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0085			JA	01	15		1.00	INST BEARING BORE BUSH & CUP	.077	.012	.089	6
0010 E						REW-BU-S1	.25	SET UP TO REBUSH BOSSES PRGRATE OVER 8 PARTS	.18669		.053	
0020 E						REW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062		.023	
0030 E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
9000			JA	01	15		1.00	LABOR STANDARD HISTORY	.000	.000	.000	0
0900								C. W. RIGBY MANEL-1 73357				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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INPRC16267ARC150

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

11/02/88

A-E046B-MM1-DY-M45

PAGE 0001

16267A F4 N WHL 220A123

RCC INPRC

AWD-7-1142 852-1432

81290

OPER TECH S S W F R A/R REV

T K #R A FA SUPPORT

000

DESCRIPTION

BASE

FFD

STD

A

STEP D L

K D CC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

DAY FOT C

0010	S	E	UP	EA	B	J	89001	1.00	PERCENT ENGR 99.9	FAN WHEEL HALF SUBASSEMBLY	.19		.19	
0001			UP	01	00			.00		PART NUMBER/SEN	.000	.000	.000	0
0010							220A283			1630011532016				
0070			UP	01	24			1.00		ANDDIZE SMALL PART	.156	.007	.193	18 100
0010	E						FWB-DV-B1	1.00	VAPOR CL (DEBRIDOCK/BASKET		.03709		.107	
0020	E						ZPL-AN-B1	1.00	ANDDIZE SMALL PART		.05592		.070	
0030	E						RJP-FW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC		.01601		.012	
0000			UP	01	24			.01		LABOR STND HISTORY	.000	.000	.000	0
0010									00JUN86 REWROTE STD TO MATCH 958 WORK PREVIOUSLY					
0011									DONE ON OPERATION INPRC (OLD STND WAS 1215)					
0900									HARRY COOP MANEL TECHN 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC FFD NRCP NR

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1626TA FA NWHL 2204107

ACC MAFRC

AWD-7-1147 852-1432 81290

ST TECH B B W F F A/R REV

T K R A FA SUPPORT

000

DESCRIPTION

BASE

AFD

STD

A

STEP D L K C DO ELEMENT FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

OLY PCT C

0155	B	E	UP	CH	B	0	887001	1.00	PERCENT ENGR 99.9	FA NOSE WHEEL HALF SUBASSY 1	.19		.19		
0001						00		.00		PART NUMBER/NSN	.000	.000	.000	0	
0010							000A282			1630011611591					
0070						24		1.00		ANODIZE SMALL PART	.156	.037	.192	.8 100	
0010	E						FWB-HV-01	1.00	VAPOR CL (DEGR)HOOK/BASKET		.06709		.107		
0001	E						2FL-HN-61	1.00	ANODIZE SMALL PART		.05392		.073		
0000	E						RCP-RW-61	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.012		
0100						24		.01		LABOR STD HISTORY	.000	.000	.000	0	
0010							000UN86		REWROTE STD TO MATCH 958 WORK PREVIOUSLY						
0011									DONE ON OPERATION XNFRG (OLD STD WAS .225)						
0000									KERRY COOP MANEL TECHN 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

ACC AFD MAFRC NA

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16267A F4 N WHL 220A123

RCC MMFSP

4W3-7-1143

81279

TECH S S W F PF A/R REV

T K #R A F4 SUPPORT OCC

STEP D L K C DC ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE  
HOURS

PFD  
TIME

STD  
HOURS

A  
DLY PCT C

PS150	S	E	YH	EA	5	J	88301	1.00	PERCENT ENGR 99.9	PREASSY F4 NOSE WHEEL O/B	.28		.29		
0001			YH	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0	
0010							220A283			1630011532016					
0090			YH	01	21			1.00		PREINSPECTION WHEEL HALF	.015	.003	.019	7	
0010	E						RWB-JP-W2	1.00	PREP TO ASSY OR DISSY WHEEL		.00442		.005		
0020	E						KAL-EC-46	1.00	INSPECT VISUAL		.00115		.001		
0030	E						RJP-PH-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012		
0095			YH	01	21			1.00		RACE INSTALLATION WHL/HALF	.178	.037	.215	76	
0010	E						RWB-BC-03	1.00	INSTALL BEARING CLIPS		.16838		.203		
0020	E						RJP-PH-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012		
0115			YH	01	21			1.00		INSTALL SEALS & RETAINERS	.041	.009	.050	18	
0010	E						RWB-AW-B1	1.00	INSTL BEARING/SNAP RING SECURD		.02459		.029		
0020	E						RWB-AW-C1	1.00	INSTL TIRE CHANGE DATA PLATE		.00692		.008		
0030	E						RJP-PH-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012		
9000			YH	01	21			.01		LABOR STANDARD HISTORY	.000	.000	.000	0	
0010									06JUN84 ADD SUB OP 0001 UNLOAD LINE(OLD STD)	.70					
0020									25SEP84 ADD STEPS 0007 & 0008 SUB OP 0010						
0021									(OLD STANDARD).78						
0030									10DEC84 2 REAR REVIEW/NO TIME CHANGE						
0031									7MAR86 CHANGED SKILL CODE FROM YG TO YH						
0032									NO TIME CHANGE						
0900									KERRY COOP MANEAA TECHN 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

04/26/89

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16267A F4 N WHL 220A123

RCC MNPGR

4W3-7-1143

81279

TECH S S W F PF A/R REV

T K #R A FA SUPPORT OCC &lt;----- DESCRIPTION -----&gt;

STEP D L K C DC ELEMENT FACT STORED SUPPLEMENTAL

BASE PFD STD A  
HOURS TIME HOURS DLY PCT C

PS155	S	E	YH	EA	5	J	88301	1.00	PERCENT ENGR 99.9	PREASSY F4 NOSE WHEEL I/B	.28		.28	
0001			YH	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0
0010							220A282			163001161159				
0090			YH	01	21			1.00		PREINSPECTION WHEEL HALF	.015	.003	.019	7
0010	E						RWB-JP-W2	1.00	PREP TO ASSY OR DISSY WHEEL		.00442		.005	
0020	E						KAL-6C-46	1.00	INSPECT VISUAL		.00115		.001	
0030	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
0095			YH	01	21			1.00		RACE INSTALLATION WHL/HALF	.178	.037	.216	76
0010	E						RWB-BC-03	1.00	INSTALL BEARING CUPS		.16838		.203	
0020	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
0115			YH	01	21			1.00		INSTALL SEALS & RETAINERS	.041	.009	.050	18
0010	E						RWB-AW-B1	1.00	INSTL BEARING/SNAP RING SECURD		.02459		.029	
0020	E						RWB-AW-C1	1.00	INSTL TIRE CHANGE DATA PLATE		.00692		.008	
0030	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
9000			YH	01	21			.01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010									06JUN84 ADD SUB OP 0001 & UNLOAD LINE<OLD STD>				.70	
0020									25SEP84 ADD STEPS 0007 & 0008 SUB OP 0010					
0021									<OLD STANDARD>.78					
0030									10DEC84 2 REAR REVIEW/NO TIME CHANGE					
0031									7MAR86 CHANGED SKILL CODE FROM Y6 TO YH					
0032									NO TIME CHANGE					
0900									KERRY COOP MANEAA TECHN 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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RCC MNPSP

4W3-7-1143

81279

R TCH S S W F PF A/R REV

S T K NR A FA SUPPORT OCC

STEP D L K C DC ELEMENT FACT

DESCRIPTION

BASE

FFD

STD

A

HOURS

TIME

HOURS

DLY PCT C

56	S	E	YH	EA	5	J	28301	1.00	PERCENT ENGR 94.5	MATCH UP F4 NOSE WHEEL	.13		.13	
0001			YH	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0
		00.0					220A123			1630008521432				
0010			YH	01	21			1.00		WHEEL MATCH UP	.110	.023	.134	100
	0010	E					MGT-EE-24	1.00	GET EASY AND PLACE EXACT		.00097		.001	
	0020	E					SNB-UP-P7	1.00	UNFK PARTS-BK KEY-SNAP RING		.08237		.099	
	0030	N						1.00	MATCH WHEEL HALFS 2 HALFS		.01700		.020	
	0040	E					RCP-FW-R1	1.00	REM SPL PAPERWK SIGN OFF OCC		.01001		.012	
9000			YH	01	21			.01		LABOR STANDARD HISTORY	.000	.000	.000	0
	0010								06JUN84 ADD SUB OP 0001 & UNLOAD LINE<OLD STD> .70					
	0020								25SEP84 ADD STEPS 0007 & 0008 SUB OP 0010					
	0021								<OLD STANDARD>.78					
	0030								10DEC84 2 REAR REVIEW/NO TIME CHANGE					
	0031								7MAR86 CHANGED SKILL CODE FROM YG TO YH					
	0032								NO TIME CHANGE					
	0900								KERRY COOP MANEAA TECHN 73357					

INTERROGATE LABOR STANDARDS. INPUT

DC 990 NRGP NR

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

11/02/88

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16267A F4 N W/L 220A123

RCC MNPSP

4W3-7-1143

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R TECH S S W F F A/R REV

S	T K	#R A	FA	SUPPORT	CCC	DESCRIPTION	BASE	PRD	STD	A
SEP D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C

10	S	E	YH	EA	5	J 38301	1.00	PERCENT ENGR 99.9	ASSY F4 NOSE WHEEL	.05	.05	
0001			YH	01	00		.00		PART NUMBER/NSN	.000	.000	.000
			0010			220A123			1630008521432			
0015			YH	01	21		1.00		FINAL WHL ASSEMBLY SM/NOERK	.049	.010	.059
			0010	E		RWB-AW-T1	4.00	INSTL UNOBSTRUCTED TIE BOLT		.00975		.047
			0020	E		RJP-FW-R1	1.00	REM RPL PAFSWRK SIGN OFF DOC		.01001		.012
9000			YH	01	21		.01		LABOR STANDARD HISTORY	.000	.000	.000
			0010			06JUN84		ADD SUB OP 0001 UNLOAD LINE(OLD STD)		.70		
			0020			25SEP84		ADD STEPS 0007 & 0008 SUB OP 0010				
			0021					(OLD STANDARD).78				
			0030			10DEC84		2 REAR REVIEW/NO TIME CHANGE				
			0031			7MAR86		CHANGED SKILL CODE FROM YG TO YH				
			0032					NO TIME CHANGE				
			0900					KERRY COOP MANEAA TECHN 73357				

INTERROGATE LABOR STANDARDS. INPUT

CC PRD NROP NR

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

11/02/88

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16267A F4 N WHL 220A123

RCC MNFGP

4W3-7-1143

81279

ES TECH S S W F PF A/R REV

STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	EASE HOURS	FFD TIME	STD HOURS	A DLY PCT C
150	S	E	38	EA	5	J 88001	1.00	PERCENT ENGR 99.9	PAINT F4 NOSE WHEEL D/B		.33		.33	
0001			38	01	00		.00		PART NUMBER/NSN		.000	.000	.000	0
			0010			220A283			1630011532016					
0110			38	01	25		1.00		PAINT WHEEL		.267	.067	.334	4.0 100
0010	E					GPL-PA-01	4.00	INST NONTHEADED PLSTC PLUG			.00093		.004	
0020	E					GIS-SF-M1	1.00	MASK & UNMASK MEDIUM PART			.01242		.015	
0030	E					RWB-OH-W1	1.00	HANG WHL HLF ON PAINT CONVYR			.02336		.029	
0040	E					RWB-SC-02	1.00	PNT WHL HALF-ZINC CHROMATE			.11574		.144	
0050	E					RWB-SC-P3	1.00	PNT WHL HALF (2ND COAT)	POLY 2 COATS		.10214		.127	
0060	E					RJP-FW-R1	1.00	REM RPL PAPRWK SIGN OFF DCC			.01001		.012	
9000			38	01	25		.01		LABOR STANDARD HISTORY		.000	.000	.000	0
0010								06JUN84 REMOVE UNLOADING PAINT LINE <GLD STD> .57						
0020								25SEP84 ADD STEPS 0005 & 0006 SUB OP 0010						
0021								<GLD STD> .55						
0030								10DEC84 2 YEAR REVIEW/NO TIME CHANGE						
0900								N MONROE/MANEAA						

J INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NRCP NR

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J 0123456 ELSE PUT IN END

R TECH S S W F F F A/R REV

S T K #R A FA SUPPORT GCC

SEP D L K C DC ELEMENT FACT

DESCRIPTION

STORED

SUPPLEMENTAL

BASE  
HOURSPFD  
TIMESTD  
HOURSA  
DLY PCT C

55	S	E	JS	EA	5	J	28301	1.00	PERCENT ENGR 99.9	PAINT F4 NOSE WHEEL I/B	.33		.33		
0001			JS	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0	
							220A282			163001161159					
0100			JS	01	25			1.00		PAINT WHEEL	.267	.067	.334	4.0	100
0010	E						GFL-PA-01	4.00	INST NONTHEADED PLSTC PLUG		.00093		.004		
0020	E						SIG-SP-M1	1.00	MASK & UNMASK MEDIUM PART		.01242		.015		
0030	E						RWB-CH-W1	1.00	HANG WHL HLF ON PAINT CONVYR		.02336		.029		
0040	E						RWB-SC-02	1.00	PNT WHL HALF-ZINC CHROMATE		.11574		.144		
0050	E						RWB-SC-P3	1.00	PNT WHL HALF (2ND COAT) POLY 2 COATS		.10214		.127		
0060	E						RCP-FW-R1	1.00	REM RPL PAPRWRK SIGN OFF BCC		.01001		.012		
9000			JS	01	25			.01		LABOR STANDARD HISTORY	.000	.000	.000	0	
0010									06JUN84 REMOVE UNLOADING PAINT LINE (OLD STD)	.57					
0020									25SEP84 ADD STEPS 0005 & 0006 SUB OP 0010						
0021									(OLD STD) .55						
0030									10DEC84 2 YEAR REVIEW/NO TIME CHANGE						
0900									N MCRCE/MANEA						

INTERROGATE LABOR STANDARDS. INPUT

CC FRD NSOP NR

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141 0123456 ELSE PUT IN END

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/02/88 A-E046B-MM1-DY-M45 PAGE 0001  
162572 F4 N WML 220A123 RCC MNPSR 4WS-7-1143 81279

INTERROGATE LABOR STANDARDS, INPUT

REF ID: A66087

$$-X- -X-$$

14567890123456 ELSE PUT IN END